



# BETACHROME 13/4 LB-R

STAINLESS STEEL (Plain Chrome Series)

AWS A/SFA 5.4 **E410NiMo-16**

### CLASSIFICATION:

**ISO 3581-A**  
E 13 4 R 12

**IS 5206**  
E 13.4 R26

### KEY FEATURES:

- Rutile type electrode
- High strength, toughness and cracking resistance
- Smooth ARC characteristics
- Easy slag removal
- Martensitic type alloy resistant to corrosion, erosion, pitting and impact
- Preheat and PWHT recommended
- All position welding capability
- Radiographic quality weld

**APPROVALS:** CE

### TYPICAL APPLICATIONS:

- Welding of ASTM CA 6NM casting or similar materials as well as light gauge 410, 410S and 405 base metals
- Welding of extra low carbon castings and forgings of similar composition and surfacing applications
- Surfacing of turbine blades, high pressure valves
- Repair of runners, valve seats, pulp and paper plant equipment
- German castings/forgings type GX5CrNi13.4 and G-5CrNi13.6, VIRGO 104 casting/forging


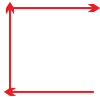
### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.05	0.7	0.5	12.3	4.5	0.6

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	PWHT: 600°C for 1 hr	760 min	15 min

### PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 60-80 80-120 110-160	 <b>DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down  

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.

### EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 410NiMo	Tiginox 410NiMo	Miginox FC 410NiMo	Automelt S33	Subinox 410NiMo