



## BETACHROME 17/4

STAINLESS STEEL (Plain Chrome Series)



Special Electrode for surfacing and Welding of stainless steel casting

**CLASSIFICATION : EN ISO 3581-A**

E 17 4 R 12

### KEY FEATURES :

- Basic coated electrode
- Proper preheating and PWHT is required to achieve desired mechanical properties
- Typical 17Cr/4Ni/1Mo weld deposit
- Stable arc and low spatter
- All position welding capability
- Radiographic quality weld deposit

### WELDING POSITION :



DCEP

### TYPICAL APPLICATIONS :

- Suitable for welding of stainless steel castings of similar composition
- Automotive body moulding, Oil burner parts, Surfacing valve seats

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

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

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>S</b>	<b>P</b>
Typical	0.08	0.5	0.6	17.4	4.5	1.1	0.02	0.02
Specification	0.05-0.10	0.20-0.60	0.30-0.80	16.0-18.5	3.5-5.0	0.90-1.20	0.03 max	0.04 max

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Carton/Box</b>	<b>Net wt./Box, Kg.</b>
2.0 x 300	50-70	2	5	10
2.5 x 350	80-120	2	5	10
3.15 x 350	130-180	2	5	10
4.0 x 350	170-220	2	5	10