

BETACHROME 17Cr

AWS A/SFA 5.4 E430-15

STAINLESS STEEL (Plain Chrome Series)

CLASSIFICATION:

EN ISO 3581-A
E 17 B 22

IS 5206
E 17 R26

KEY FEATURES:

- Basic coated electrode
- Typical 17Cr ferritic alloy
- Proper preheating and PWHT will achieve desired properties
- Air hardenable weld deposit
- Excellent arc stability and low spatter
- All position welding capability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- For welding ferritic martensitic chrome steels and steel castings of similar composition
- For general corrosion and heat resisting applications
- Cladding of exhaust valves
- Joining and cladding of 17Cr alloy
- For cladding where temperature and corrosion resistance is necessary
- For cutlery, pump parts, castings, oil refinery equipments
- Suitable for material 1.4057, 1.4740, 1.4742, 1.4059 and AISI 430 steel

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr
0.07	0.5	0.45	16

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	PWHT: 775°C for 2 hrs	560	27
Specification		450 min	20 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	60-100	 DCEP	All Positions, except vertical Downwards
2.5 x 350	80-120		
3.15 x 350	130-160		
4.0 x 350	170-220		
		REDRYING CONDITION: 250-300°C for minimum 1 hr.	

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

EQUIVALENT:

GMAW	GTAW	SAW	
		Flux	Wire
Miginox 430	Tiginox 430	Automelt S33	Subinox 430