



BETACHROME 17Cr

STAINLESS STEEL (Plain Chrome Series)



Ferritic stainless steel Electrode for joining and surfacing application

CLASSIFICATION : EN ISO 3581-A

AWS A/SFA 5.4

E 17 B 22

E 430-15

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

WELDING POSITION :



DCEP

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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
Typical	0.06	0.6	0.4	17.3	0.2	0.2	0.02	0.02	-
Specification	0.10 max	1.0 max	0.90 max	15.0-18.0	0.6 max	0.75 max	0.03 max	0.04 max	0.75 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

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

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	60-100	2	5	10
2.5 x 350	80-120	2	5	10
3.15 x 350	130-160	2	5	10
4.0 x 350	170-220	2	5	10