



BETACHROME ND

STAINLESS STEEL (Plain Chrome Series)

CLASSIFICATION:

ISO 3581-A
E 18 8 Mn B 22

IS 5206
E 18.8 Mn B20

KEY FEATURES:

- Basic coated electrode
- 18/8/5Mn type austenitic weld deposit
- Excellent heat resistant properties upto 900°C
- Radiographic quality weld
- Work hardenable alloy with excellent crack resistance
- Excellent arc characteristics
- Suitable for all position

APPROVALS: CE

TYPICAL APPLICATIONS:

- For joining austenitic Mn (12%) steel to mild steel
- Surfacing Mn steel, Crane wheels
- Joint welding between unalloyed or low alloyed steels with high alloyed steels or cast steels
- For buffer layer on difficult steels before hardfacing
- Welding steel with difficult weldability
- Armour plates, Crusher cones, Crusher hammers, Rail crossings, Shovel bucket teeth


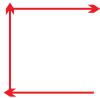
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.035	5.5	0.75	19	9.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	600	36
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	50-75	 DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 350	80-110	
4.0 x 350	110-150	

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