

BETACHROME ND SPL

STAINLESS STEEL (Dissimilar Steel Welding)

CLASSIFICATION:

ISO 3581-A

E 18 8 Mn B 12

IS 5206

E 18.8 Mn B20

KEY FEATURES:

- Basic type semi-synthetic electrode
- Medium-heavy coated
- 18/8/5Mn type austenitic weld deposit
- Work hardenable alloy
- Excellent crack resistance combined with superior toughness properties
- Minimum spatter losses
- Easy slag detachability
- Suitable for all position

APPROVALS: CE

TYPICAL APPLICATIONS:

- Specially designed for joining high tensile Armour steel, Bullet proof steel, Hardox 400, Hardox 500
- Fabrication of ICVBMP-11/T-72 tanks
- Joining and laying buffer layers on difficult to weld steel before hard facing
- Austenitic Mn steel (Hadfield steel) to mild steel joining
- Repairing cracks in austenitic Mn steel parts e.g. Shovel bucket teeth, Stone crushers, Hammers, Points and Crossings


TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	Cu
0.04	5.6	0.75	18.7	8.9	0.6	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	CVN Impact at 27°C, J
Typical	As Welded	650	37	110
Specification		560 min	30 min	47 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 AC (90 OCV)/DCEP	All Positions, except vertical Downwards
2.0 x 300	50-75		
2.5 x 350	80-100		
3.15 x 350	110-140		
4.0 x 350	150-200		
		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.