



BETACHROME ND SPL

STAINLESS STEEL (Plain Chrome Series)



18/8/5Mn type Electrode for joining high tensile Armour steel & hardox steel

CLASSIFICATION : ISO 3581-A

IS 5206

E 18 8 Mn B 12

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

WELDING POSITION :



AC (90 OCV)/DCEP

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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Typical	0.06	6.5	0.6	20.2	10.2	0.7	0.4	0.01	0.02
Specification	0.12 max	5.0-7.0	0.30-0.80	18.0-22.0	8.5-11.2	0.50-0.80	0.75 max	0.025 max	0.04 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	CVN Impact at 27°C, J
Typical	As Welded	650	37	105
Specification		560-770	30-40	95 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-75	2	5	10
2.5 x 350	80-110	2	5	10
3.15 x 350	110-150	2	5	10
4.0 x 350	150-200	2	5	10