



BETACHROME ND

STAINLESS STEEL (Plain Chrome Series)



Basic type stainless steel Electrode for joining & surfacing of austenitic Mn steel

CLASSIFICATION : ISO 3581-A

IS 5206

E 18 8 Mn B 22

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

WELDING POSITION :



DCEP

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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

| | C | Mn | Si | Cr | Ni | S | P |
|---------------|----------|-----------|-----------|-----------|-----------|----------|----------|
| Typical | 0.08 | 5.7 | 0.7 | 19.5 | 9.4 | 0.01 | 0.01 |
| Specification | 0.12 max | 5.0-7.0 | 0.30-0.80 | 18.0-21.0 | 8.5-11.0 | 0.03 max | 0.04 max |

MECHANICAL PROPERTIES OF ALL WELD METAL :

| | Condition | UTS, MPa | EL% |
|---------------|------------------|-----------------|------------|
| Typical | As Welded | 600 | 36 |
| Specification | | 560-670 | 30-40 |

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 |