



BETACHROME 13Cr

STAINLESS STEEL (Plain Chrome Series)

AWS A/SFA 5.4 E410-15

CLASSIFICATION:

ISO 3581-A
E 13 B 22

IS 5206
E 13 B26

KEY FEATURES:

- Basic coated electrode
- Typical 13Cr martensitic alloy
- Proper preheating and stress relieving required to avoid hardening
- Air hardenable weld deposit
- Stable arc and low spatter loss
- All position capability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- For welding ferritic martensitic chrome steels and steel castings
- For general corrosion and heat resisting applications
- Cladding of exhaust valvesmufflers, manifolds, manifold elbows
- For cutlery, pump parts, castings, oil refinery equipments
- Suitable for 1.4000, 1.4002, 1.4006, 1.4021, 1.4024 and AISI 410/420 steel


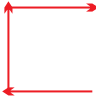
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr
0.07	0.5	0.25	12.2

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	PWHT: 745°C for 1 hr	570	27
Specification		520 min	20 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-70	 AC (70 OCV)/DCEP REDRYING CONDITION: 300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	80-120		
4.0 x 350	130-160		

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

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 410	Tiginox 410	Miginox FC 410	Automelt S33	Subinox 410