

BETACHROME 13Cr

CLASSIFICATIONS

AWS A/SFA 5.4 E 410-15

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode for welding of Ferritic Martensitic Chrome steels. The weld metal contains ~13%Cr and is of air-hardenable type. Hardening can be avoided through preheating and stress relieving. Weld metal is of radiographic quality. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

TYPICAL APPLICATIONS

For welding of Ferritic Martensitic Chrome steels and steel castings. Used in general corrosion and heat resisting applications. For cutlery, pump parts, castings, Oil refinery equipments, etc.

CURRENT CONDITIONS:

			DC (+)
5.0	4.0	3.2	2.5
170-220	130-160	80-120	50-70

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour
(Optionally also available in vacuum-packed condition.)

WELD METAL CHEMISTRY, (%)

C - 0.10 max.	S - 0.03 max.	Cr - 11.0-13.50
Mn - 1.0 max.	P - 0.04 max.	Cu - 0.50 max.
Si - 0.20-0.65	Ni - 0.7 max.	Mo - 0.50 max.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd) 20 min.
PWHT : 740°C/1hr	520 Min.	

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	300	300	300	300
Wt. per carton, kg	2	2	2	2
Cartons / box	5	5	5	5
Net wt per box, kg	10	10	10	10



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ADOR WELDING LIMITED

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