

# BETACHROME 17Cr

## CLASSIFICATIONS

**AWS A/SFA 5.4** E 430-15

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

An electrode for welding of Ferritic Martensitic Chrome steels. The weld metal contains ~17%Cr and is of air-hardenable type. Weld metal properties can be achieved through proper preheating and Post heat treatment. 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. AISI 430 SS. Used in general corrosion and heat resisting applications. For pump parts, castings, Oil refinery equipments etc.

### WELD METAL CHEMISTRY, (%)

C - 0.10 max.	S - 0.03 max.	Cr - 15.0-18.0
Mn - 1.0 max.	P - 0.04 max.	Mo - 0.75 max.
Si - 0.15-0.60	Ni - 0.6 max.	

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd) 20 min.
PWHT : 770°C/2hrs	490 min.	

## CURRENT CONDITIONS: DC (+)

5.0	4.0	3.2	2.5
170-200	130-160	80-120	60-100

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

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

### 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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