



BETACHROME N

HARD FACING (High Impact - Work Hardenable)

ALLOY BASIS

C, Mn, Si, Cr

KEY FEATURES:

- Basic coated synthetic electrode
- C-Cr-Ni-Mn type austenitic weld deposit
- Smooth arc characteristics
- High plasticity weld deposit
- Excellent heat resistance upto 900°C
- Work hardenable alloy with excellent crack resistance
- Suitable for all position

TYPICAL APPLICATIONS:

- For joining austenitic 12% Mn steels to mild steels
- Surfacing Mn steel, Crane wheels
- Welding of unalloyed or low alloyed steels to high alloyed steels or cast steels
- Buffer layer on difficult steels before hardfacing
- Suitable for steels of difficult weldability
- Armour plates, steel castings, crusher cones, crusher hammers

MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, MPa	EL%
As Welded	600	35

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-75	 AC (70 OCV) / DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	80-110		
4.0 x 350	110-150		
5.0 x 350	150-200		

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

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

Physical Properties: With increase in number of squares, property improves