

Typical Applications:

- Supermartensitic 13Cr steels

Product Advantages:

- Flat, Horizontal Positions
- Modified chemistry for high yield in HAZ
- High Strength after PWHT
- Excellent toughness

Deposit Composition							
	%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
BH13Cr	0.01 max	1.0 – 2.0	1.0 max	6.0 – 7.0	2.0 – 3.0	12.0 – 13.0	0.5 max

Available Diameters: 1/8", 3/32" (Additional sizes may be available upon request)

Typical Welding Parameters		
Diameter	Amperage Range	Current
3/32"	150-160	DCEN
1/8"	180-190	DCEN

Packaging: Electrodes are vacuum-sealed in 10 lb. boxes in a climate-controlled room to eliminate all moisture.

Moisture Control: Devasco electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40°F to 120°F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 300-325°F in a warming oven for a minimum of 2 hours prior to use.

NOTICE: Data provided is based on typical results. **Actual results are tested per customer spec.** Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. www.devasco.com for additional information.
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