

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -15

HYDROGEN CONTROLLED ELECTRODE FOR MILD, MEDIUM CARBON, HIGH STRENGTH STEELS, CAST STEELS AND FOR CUSHION LAYER UNDER HARD DEPOSITS.

CHARACTERISTICS

RASI WE - 15 is a hydrogen controlled electrode, operates well in all conventional positions. The weld metal is extremely ductile and resistant to cracking. The weld metal is of RADIOGRAPHIC quality. The weld bead has good appearance and slag peels off by itself.

APPLICATIONS

RASI WE - 15 For joining and building up to low and medium carbon steel. Ideal for joining dissimilar sections, restrained joints. Used as a cushion layer below hard deposits. Find application in pressure vessels, pipes, steel castings, heavy machinery parts etc.

TECHNICAL DATA

Ultimate Tensile Strength: 55 Kgf/mm²(Typical)

Elongation Percent: 28% (Typical)

CURRENT RANGE : AC/DC (+)

SIZE MM: 2.5 | 3.15 | 4.0 | 5.0

AMPS: 60-90 | 90-120 | 120-160 | 150-200

ALLOY BASIS : C, Mn, Si, Fe

PACKAGING

2 Kgs in one Plastic Carton and 10 Kgs in one Box.

STORAGE

Before using, confirm the electrodes are absolutely dry as packed. If exposed and damp, heat them to 250oC for one hour and use.