

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -16S

An electrode for high strength and extreme crack resistance.

CHARACTERISTICS

The electrode has very soft Arc and gives smooth and defect free austenofertic weld metal. The deposit is resistant to friction, heat and corrosion, is work hardening and shock proof.

APPLICATIONS

Welding of Heavy machine parts, earth moving equipments, Automobile springs, trunnion of cement mill and other allied components, parts subjected to heat, corrosion and impact. Joining and surfacing of difficult to weld steel and un - identified steels for joining dissimilar steels.

TECHNICAL DATA

Ultimate Tensile Strength: 75-85 Kgf/mm²(Typical)

Elongation Percent: 22-25% (Typical)

Hardness : 230 BHN

CURRENT RANGE : AC/DC (+)

SIZE MM: 2.5 3.15 4.0 5.0

AMPS: 50-80 75-95 90-120 120-160

ALLOY BASIS : Fe, Cr, Ni, Mn

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 300C for one hour and use.