

## RASI ULTRA-TECH

### TECHNICAL SPECIFICATION SHEET

#### LOW HEAT INPUT WELDING ALLOYS

##### RASI WE -18T

A CHROMIUM - NICKEL - MANGANESE ALLOY FULLY AUSTENITIC ELECTRODE FOR HIGH RESISTANCE TO CORROSION AND THERMAL SHOCK RESISTANCE.

#### CHARACTERISTICS

RASI WE - 18 T is a stainless steel electrode with low spatter, self disposing slag, finely rippled extra ordinary weld metal. Resists scaling and shock at ordinary and elevated temperatures up to 800C Possesses work hard-ening properties. Ease of welding is an advantage, Radiographics quality tough crack - resistant deposit. High welding stresses can be absorbed by the weld deposit.

#### APPLICATIONS

Weld joins alloyed and unalloyed steels, manganese alloy steels and between manganese alloy steel and several other steel grades. The deposit alloy cold hardens under impact. Hence, the electrode may be used for weld surfacing of cold - hardening components such as curved sections of RAilway lines, Shunt points, Crusher cones. Also serves as a buffer layer for absorbing shocks after hard surfacing on above mentioned steels.

#### TECHNICAL DATA

Tensile Strength : 580-640N/mm<sup>2</sup>

Elongation: 33%

As welded Hardness : 190-210 BHN

Work Hardened: Approx. 450 BHN

Charpy V Impact : 60 Joules at R.T.

#### CURRENT RANGE : AC/DC ( + )

SIZE MM: 2.5 3.15 4.0 5.0

AMPS: 60-70 80-120 120-140 140-180

ALLOY BASIS : C, Cr, Ni, Mo, Mn, 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 300C for one hour and use.

storage - Store in warm and dry place. If damped re dry at 100-110°C for 30 minutes.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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