

## RASI ULTRA-TECH

### TECHNICAL SPECIFICATION SHEET

#### LOW HEAT INPUT WELDING ALLOYS

##### RASI WE -19

A SYNTHETIC UNIVERSAL STAINLESS STEEL ELECTRODE FOR A WIDE VARIETY OF APPLICATIONS.

#### CHARACTERISTICS

RASI WE - 19 is a high deposition efficiency electrode, which deposits about 20Cr. 9Ni, 5 Mn, with moly type stainless steel. Excellent slag detachability with shining & uniform beads are some of the special features. The weld metal is strong, ductile, tough and work hardening in nature. The weld metal is having good resistance to wear, abrasion, corrosion, oxidation and to impact.

#### APPLICATIONS

For welding of austenitic manganese steel to themselves and to other steels such as mild steels, alloy steels, Chromium steels, carbon steels, stainless steels etc. Repair welding of manganese steel parts, parts subjected to heavywear like railway points & crossings etc. Best suitable as buffer layer before hardfacing.

#### TECHNICAL DATA

Tensile Strength : 65Kgf/mm<sup>2</sup>

Elongation : 35%

weld recovery : 130%

As welded Hardness : 190-210 BHN

Work Hardened: 420-475 BHN

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

SIZE MM: 2.5    3.15    4.0    5.0

AMPS: 85-120 120-160 150-200 170-250

ALLOY BASIS : C, Cr, Ni, Mo, Fe, 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.