

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -19H

AN ELECTRODE FOR HEAT RESISTANCE.

CHARACTERISTICS

RASI WE 19H Easy Arc striking, easy slag removal, weld metal can withstand temperature above 1000C in continues Service. Excellent creep rupture strength at elevated temperature.

APPLICATIONS

RASI WE 19H For Welding of furnace parts made of HF alloys used in fertilizer Industries, Oil refineries, Petrochemical plants, Heat treatment plant etc.

TECHNICAL DATA

Tensile Strength : 65Kgf/mm²

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.