

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -25

A SPECIAL ELECTRODE PRODUCING OUTSTANDING QUALITY WELDS ON CAST IRON. DEPOSITS ARE FULLY MACHINABLE.

CHARACTERISTICS

RASI WE 25 contains specially formulated flux coating that enables the electrode to produce very smooth arc, at very low temperature which is essential for cast iron welding to avoid dilution with the base metal and minimise the heat input. The electrode produces crack free machinable weld deposits on all weldable cast iron.

APPLICATIONS

RASI WE 25 is specially recommended for sound and crack free weld deposits on gray cast iron, spheroidal iron, malleable cast iron to themselves or to each other or to steel. this electrode can effectively be used in joining the above castings to monel or copper alloys. Repair welding of valve bodies, engine blocks, sprockets, gears, pump casings and filling the cavities of new defective castings are some of the many other similar applications.

TECHNICAL DATA

Tensile Strength : 33Kgf/mm²

Elongation: 20%

Hardness : 160 - 180 BHN

CURRENT RANGE : AC/DC (+)

SIZE MM: 2.5 3.15 4.0 5.0

AMPS: 60-80 90 - 110 80-120 140-170

ALLOY BASIS : Ni

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 100C for one hour and use.