

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -25F

A SPECIALLY FORMULATED PURE NICKEL TYPE GRAPHITE COATED FOR WELDING OF KNOWN / UN KNOWN CAST IRON.

CHARACTERISTICS

Smooth stable arc, Suitable for positional welding, Very little mixing with base metal, consequently the HAZ is easily machinable.

APPLICATIONS

A unique electrode for cold welding of Cast Iron without preheating and for joining of Cast Iron to Mild Steel. Also suitable for surfacing of cast Iron parts subjected to erosion, Corrosion and high temperatures. Best suitable for repairing intricate Cast Iron parts, water pump housings, electric moto bodies and covers, machine frames, cylinder blocks & gears. Also ideal for salvaging foundry castings, gear box, differential housing, lathe beads, sugar mill rollers, glass moulds, cast iron dies etc.

TECHNICAL DATA

Ultimate Tensile Strength: 30-35 Kgf/mm²

Hardness : 100-130 BHN

CURRENT RANGE : AC/DC (+)

SIZE MM: 2.5 3.15 4.0

AMPS: 40-70 60-100 80-120

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 100 C for one hour and use.