

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -27

A SPECIALLY FORMULATED ELECTRODE FOR HIGH STRENGTH MACHINABLE WELDS ON GREY AND ALLOY CAST IRON.

CHARACTERISTICS

RASI WE 27 is a Specially formulated electrode for welding the difficult to weld cast irons. The deposit is machinable and crack - free. The arc is stable even at low current ranges, and this minimises dilution of weld metal with parent metal. Slag coverage is complete and detachability is excellent.

APPLICATIONS

RASI WE 27 The electrode can best be used with castings, machinery parts, frames, foundry cast blocks, bearing blocks and joining of cast iron to steel, hot and cold welding of cast iron, grey cast iron, nodular cast iron, malleable cast iron. It can also be used on machine beds, pump casing, valve bodies, valve flange, bell housing etc.

TECHNICAL DATA

Tensile Strength: 35-40 Kgf/mm²

Hardness : 180-210 BHN

CURRENT RANGE : AC/DC (-)

SIZE MM: 2.5 3.15 4.0 5.0

AMPS : 40-80 80-120 100-140 120-170

ALLOY BASIS : Ni, 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 100C 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.