

## RASI ULTRA-TECH

### TECHNICAL SPECIFICATION SHEET

#### LOW HEAT INPUT WELDING ALLOYS

##### RASI WE -33

AN ALL POSITION EXTRA LOW CARBON 18 Cr. 8 Ni STAINLESS STEEL ELECTRODE WITH CONTROLLED FERRITE CONTENT.

#### CHARACTERISTICS

RASI WE 33 is a suitably formulated electrode which gives a weld, free from inter crystalline corrosion with easy arc striking and with a shining finish.

We 33 produces weld deposits of extra low carbon with balanced Cr-Ni ratio and controlled ferrite for outstanding resistance to hazards of cracking, weld decay, corrosion and pitting. The weld deposit has excellent toughness and suitable for restrained joint welds even at low recommended currents.

#### APPLICATIONS

Welding and surfacing of stainless steel types 301, 302, 304, 305, 308 308L types. The weld metal has good resistance to inter granular corrosion and excellent crack resistability. It is suitable in chemical industries, oil refining, kitchen equipment, brewery, dairy and food industries.

#### TECHNICAL DATA

Tensile Strength: 53-60 Kgf/mm<sup>2</sup>

Elongation: 35-40%

CURRENT RANGE : AC/DC (+)

SIZE MM: 2.5 3.15 4.0 5.0

AMPS : 50-80 80 - 110 90 - 140 120 - 180

ALLOY BASIS : Fe, Cr, 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.

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.

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