

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -33M

AUSTENITIC STAINLESS STEEL ELECTRODE WITH SPECIAL FEATURES.

CHARACTERISTICS

Smooth weldability with AC/DC operations.

All position (Except vertical down)

Weld deposit is flat / concave with consistent ripple bead.

APPLICATIONS

For joining of 18/8 Stainless Steel e.g, AISI 304, 308, excellent alloy for surfacing on stabilized and unstabilized, corrosion resistant and cold tough Cr-Ni steel in Nuclear Plants, beverage industries, chemical and fertilizer, food industries etc.

TECHNICAL DATA

Tensile Strength: 52 - 64 Kgf/mm²

Elongation: 35 - 45%

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 300C for one hour and use.