RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS
RASI WE -34

A SUPERIOR EXTRA LOW CARBON ELECTRODE FOR WLEDING OF STAINLESS STEEL TYPES 316, 316L, 318 AND OTHER MOLY BEARING STAINLESS STEELS.

CHARACTERISTICS

RASI WE-34 is an austenitic electrode with extra low carbon deposit exhibiting chemical resistant properties and also resistant to inter crystalline corrosion. The surface fusion characteristics ensures excellent bonding with base metal even at very low currents and hence minimises base metal dilution. Easy arc striking and restriking, excellent weld finish and good slag, detachability.

APPLICATIONS

For Welding and surfacing of steel types 316, 316L and 317 in fertilizer, paper and chemical industries where in resistance to intergranular corrosion are required. The extra low carbon coupled with Molybdenum in the weld deposit ensures excellent resistance to carbide resistance to carbide precipitation.

TECHNICAL DATA

Tensile Strength: 55 - 60 Kgf/mm2
Elongation: 30%

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, Mo

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.

*Extra Low Carbon Version is also available Rasi WE - 34 L, Carbon : 0.04% max

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.