

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -35

A SPECIALLY FORMULATED FULL AUSTENITIC HEAT RESISTANT ALLOY STAINLESS STEEL ELECTRODE.

CHARACTERISTICS

RASI WE - 35 is fully austenitic heat resistant alloy electrode and gives a deposit which is heat resistant even at 1200C in Sulphur - free and oxide free atmosphere. WE 35 is characterised by a stable arc which is easy to strike and restrike. Easily removable slag, smooth, finely rippled welds of RADIO GRAPHIC QUALITY. The deposited weld metal is tough and excellent. Also suitable for joining of dissimilar metals or steels of unknown composition.

APPLICATIONS

Designed for elevated temperature applications requiring a high degree of oxidation resistance and high strength at temperature upto 1200C. For welding furnace parts, heat exchangers, heat treating boxes for joining stainless steel to mild steel.

TECHNICAL DATA

Tensile Strength: 50 - 55 Kgf/mm²

Elongation: 30 - 40

Impact at RT : 80 - 100 J

Hardness : 210 - 230 BHN

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 up to 300C for one hour and use.