

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -40

AN ELECTRODE FOR WELDING OF BRASS, BRONZE AND OTHER COPPER ALLOYS

CHARACTERISTICS

RASI WE - 40 is specially formulated electrode which produces machinable deposits in almost all positions. The deposit is finely rippled, smooth and uniform with easy slag detachability. The weld metal is having equal resistance to thermal & electrical conductivity similar to the base metal.

APPLICATIONS

Electrodes have been formulated for welding and surfacing of Brass, Bronze and other copper alloys (except Aluminium Bronze). They can be used for joining of pure copper and for joining of pure copper and for joining of mild steel to most non ferrous metals. Filling foundry defects in cast iron and for joining of cast iron to mild steel where dynamic load is not a factor. Best suitable for fabrication and maintenance work in chemical and other industries where copper and its alloys are in use.

TECHNICAL DATA

Ultimate Tensile Strength : 25 Kgf/mm²

Elongation: 30%

Hardness : 135 - 155 bhn

Welding current : AC/DC (+)

SIZE MM: 2.5 3.15 4.0 5.0

AMPS : 60-90 90-120 130-160 160-210

ALLOY BASIS : Cu, Sn, P.

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 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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