

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -41

JOINING AND SURFACING OF COPPER AND COPPER ALLOYS CONTAINING ALUMINIUM (ALUMINIUM BRONZE).

CHARACTERISTICS

RASI WE - 41 Electrodes are designed for welding of copper and its alloys containing Aluminium. The weld deposits are uniform with easy slag detachability.

The weld metal is having high resistance to sea water corrosion and friction wear.

The weld metal exhibits good resistance to corrosion and cavitation.

APPLICATIONS

This electrode is formulated to deposit (9% Aluminium) Aluminium bronze. It can be used on Aluminium Bronze, on most non ferrous metals, steels and cast iron and for joining of copper alloys to steel, surfacing of steel parts, sea water resistance applications like ship propellers, pump housings and impellers etc.

TECHNICAL DATA

Ultimate Tensile Strength : 45 Kgf/mm²

Elongation: 25%

Hardness : 145-165 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, Al, Fe

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 100o for one hour and use.