

## RASI ULTRA-TECH

### TECHNICAL SPECIFICATION SHEET

#### LOW HEAT INPUT WELDING ALLOYS

##### RASI WE -52

AN IDEAL ELECTRODE FOR WELDING INCONEL ALLOY 600  
AND FOR JOINING NICKEL BASED METAL WITH STAINLESS STEELS.

#### CHARACTERISTICS

RASI WE - 52 is a Nickel based electrode designed to give excellent weld performance, such as heat resistance, cold - tough, corrosion resistance alloys with high thermal shock resistance.

#### APPLICATIONS

For welding of Inconel alloys and joint welding of pressure tanks, boilers fittings, machinery and apparatus. Also for welding and differentially alloyed materials and joint welding and cold - tough Nickel steels.

#### TECHNICAL DATA

Ultimate Tensile Strength : 55-60 Kgf/mm<sup>2</sup>

Elongation: 32 - 35%

#### CURRENT RANGE : DC (+)

SIZE MM: 2.5    3.15    4.0    5.0

AMPS : 50-70 70-90 100-130 140-160

ALLOY BASIS : Ni, Cr, Fe, Mn, Nb

#### 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 250C for one hour and use.