



RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS RASI WE -61LH

A LOW HEAT INPUT ELECTRODE OF THE BASIC LOW HYDROGEN TYPE DEPOSITING MACHINABLE OVERLAYS ON VIRTUALLY ALL FERROUS MATERIALS.

CHARACTERISTICS

RASI WE - 61LH is hard facing electrode performing with a superb arc, very low spatter, self - releasing slag and finely rippled beautiful weld bead. The deposit is hard enough to accede machinability and tough enough to withstand very severe impact.

APPLICATIONS

RASI WE 61LH is a universal Electrode for hardfacing, overlay and inlay applications on all ferrous metals, components, machinery parts requiring moderate Hardness with machinability like, Sprockets, gears, shafts, axles, pinion teeth, punches, forging die blocks, tractor idler wheels and links, steel mill rolls and grids etc. It is also suitable as buffer layer for subsequent harder overlay and also for the building up of multilayer deposits on badly worn parts.

TECHNICAL DATA

HARDNESS on 2nd layer M.S.: 29-36 HRC

WELDING CURRENT : AC / DC (+)

SIZE MM:3.154.005.00CURRENT AMPS :100-140130-160160-200

ALLOY BASIS : C, Cr, Mo, 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 200Cfor 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. WWW.rasielectrodes.com

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