

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: 3.15 4.00 5.00

CURRENT AMPS : 100-140 130-160 160-200

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 200C for one hour and use.