

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -62

AN ECONOMICAL ELECTRODE FOR PREVENTIVE PROTECTIVE COATINGS SUBJECT TO ABRASIVE WEAR AND IMPACT.

CHARACTERISTICS

RASI WE - 62 is an excellent wear resistant tough surfacing electrode which is basic in composition with excellent welding characteristics. The weld deposit is martensitic in structure and hence machining is not recommended. The alloy deposit is finely rippled and uniform which requires minimum grinding to obtain smooth final surface. For optimum results restrict alloy deposit to two/three layers.

APPLICATIONS

The electrode is well suited for surfacing of parts subjected to high abrasive wear and impact such as digger teeth, drills, conveyor screws, cutting and forming tools, punches, hot work dies, shear blades, crusher hammers, crane wheels, conveyor buckets, conveyor part, plough shares, cultivators, pulverisers, skid mixers, oil expeller worms etc. The electrode can also be used in surfacing manganese steel parts subjected to high abrasion. WE 62 is recommended as the final layer on 14% manganese weld deposit to reduce the initial wear.

TECHNICAL DATA

HARDNESS on 2nd layer M.S. : 50-55 HRC

WELDING CURRENT : AC / DC (+)

SIZE MM: 3.15 4.00 5.00

CURRENT AMPS : 80-120 110-160 150-180

ALLOY BASIS : Fe, Cr, Mo, C

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 300C for one hour and use.