

RASI ULTRA-TECH**TECHNICAL SPECIFICATION SHEET****LOW HEAT INPUT WELDING ALLOYS****RASI WE -65**

A HARDFACING ELECTRODE DEPOSITING MOLYBDENUM BEARING HIGH SPEED STEEL.

CHARACTERISTICS

RASI WE - 65 weld deposits are resistant to severe abrasion with good impact resistance. The excellent properties of this electrode are crack free, porosity - free deposits with easy slag detachability. The weld metal is tough, hard and resistant to wear and oxidation.

APPLICATIONS

The typical applications are the tipping of cutting tools, punches, cold and hot cutting, blanking and trimming dies, Brooches, drills, shears and parts subject to frictional wear. The weld metal deposits can be successfully increased in hardness by heat treatment.

TECHNICAL DATA

Hardness as welded: 60 - 62 HRC

After heat treatment: 68 HRC

CURRENT RANGE : AC / DC (+)

SIZE (MM): 3.15 4.00 5.00

CURRENT AMPS : 110-130 140-170 170-210

ALLOY BASIS : C, Cr, Mo, V, W, Fe.

PACKAGING

2 Kgs in one Plastic Carton and 10 Kgs in one Box.

STORAGE

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.

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