

**RASI ULTRA-TECH****TECHNICAL SPECIFICATION SHEET****LOW HEAT INPUT WELDING ALLOYS****RASI WE -68**

A SURFACING ELECTRODE DEPOSITS CHROMIUM CARBIDES FOR WEAR RESISTANCE ON A VARIETY OF STEELS.

**CHARACTERISTICS**

RASI WE - 68 is best suited for depositing a surface of chromium carbide which is hard and resistance to wear. It yields hard and tough deposits which have excellent resistance to abrasion in combination with high friction, and moderate impact. The alloy deposit is ripple free, smooth bead and recommended for two layer build up.

**APPLICATIONS**

RASI WE - 68 is ideally suited for surfacing machine parts subject to high stress grinding abrasion as also gouging abrasion on carbon steels, manganese steels, malleable iron and air hardenable alloy steels. Other applications include Earth moving machinery parts, bucket teeth, brick plants, cement industries, pulverizer hammers, Jaw crushers in mining, plow shares, scrapers, pug mill, fan blades, exhaust blades, conveyor parts etc.

**TECHNICAL DATA**

HARDNESS : 58-62 HRC

CURRENT RANGE : AC / DC (+)

SIZE MM:            2.5      3.15      4.00      5.00

CURRENT AMPS : 60-80 90-120 120-160 160-200

ALLOY BASIS : Fe, Cr, C, Mn.

**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 100cfor one hour and use.