



RASI HF 450R

HARD FACING WELDING ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI - HF 450 R design to give a hard and wear resistance deposit of approximate 450 brinell. Is a rutile coated AC/DC(-) electrode producing an a hardening type weld metal for hard facing of carbon and alloy steels.

APPLICATIONS

RASI - HF 450 R the weld deposit is Poor Machinable and is used for surfacing tractor rollers, Idlers in Steel mill table rollers, shovels, shear blades, sprockets, Break Shoes, forging Dies etc.

HARDNESS

HARDNESS ON THREE LAYER DEPOSIT 350-450 BHN

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.20 - 0.4%	Silicon - 0.6%
Manganese - 0.5 - 1.0%	Cr - 2.5- 3.5%

Note: Single Values shown above are maximum

PHYSICAL PROPERTIES

Machinability - Non - Machinable.
Abrasion Resistance - EXCELLENT
Impact Resistance - GOOD.
Corrosion Resistance - N.A.

WELDING CURRENT : AC / DC (-)

Ø 2.50 mm - 60-90 Amps
Ø 3.15 mm - 100-140 Amps
Ø 4.00 mm - 140-180 Amps
Ø 5.00 mm - 180-220 Amps.

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com**

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