



HARD FACING WELDING ELECTRODES

RASI HF 600LH

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI HF 600LH is a lime type low Hydrogen Iron powder hard facing electrode yielding C-Cr-Mo-Mn alloy steel deposit which is air - hardening. The electrode exhibits unmatched welding characteristics.

DEPOSIT HARDNESS - AS WELDED

550-600 Hv : 53-55 HRC on Mild steel 3rd layer. Hardness may vary below or above the designed values depending on the types, cooling and composition of the base metal .

HEAT TREATMENT

Amenable. On annealing at 6500C - 7000C for one Hour, Hardness can be reduced to 350-400 HB On the thermal quenching from 8500C - 9000C in oil/oil water Media, designed hardness can regained.

APPLICATIONS

For the hard surfacing of mild steel, Carbon steels, low alloy steels as an extremely wear and abrasion resisting layer of average to serious toughness. Stone Crusher Jaws, Rolling Mill Guides, Caterpillar treads, Earth mover wear parts, Bulldozer Blades, Caterpillar pads, Disintegrator hammers, Excavator Teeth, Dipper teeth, Conveyor screws, Muller ploughs, Oil expeller worms, Mixer scrapers, Can cutting knives, Edge runners etc.,

HARDNESS

As Welded :53-55HRC

CHEMICAL COMPOSITION OF ALL WELD METAL

CANNOT BE DISCLOSED.

PHYSICAL PROPERTIES

Machinability - Non - Machinable / ONLY Grinding
Abrasion Resistance - EXCELLENT
Impact Resistance - EXCELLENT
Corrosion Resistance - MODERATE.

WELDING CURRENT : AC / DC (-)

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**

*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.

www.rasielectrodes.com

RASI ELECTRODES LIMITED,

REDHILLS, CHENNAI - 52 | info@rasielectrodes.com | www.rasielectrodes.com | customer care no. - 044-26401822