



HARD FACING WELDING ELECTRODES

RASI HF 650R

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

C-CR-MO-NI-V-W STEEL AIR HARDENING

RASI HF 650R is a rutile based hard facing electrode with Iron powder in the coating for higher metal recovery. The running properties are welder friendly. The weld metal is a complex C-Cr-Mo-V-Ni-W alloy steel and is a special air - hardening alloy steel. Finds wide variety of applications.

DEPOSIT HARDNESS - AS WELDED

HRc 56-60 : Hv 625-700 on 3rd layer on mild steel. Hardness is likely to vary slightly above or below the designed values, depending upon the type and hardenability of the base material and rate of cooling.

APPLICATIONS

For an extremely hard and abrasive wear - resistant and a very tough surface on a variety of steel types. Dipper shovels, Lips Coupling Boxes Woodworking Tools Mud & slurry pumps, Swing Hammers, Blanking Dies, Crane Hooks, Crusher Jaws, Chuck Jaws, Dredge Pumps, Cams Punches, Pump Impellers Extrusion Dies, Clutch parts

HARDNESS

As Welded :56-60HRc

NOTE : RASI HF 650 G - Graphite coated electrode also available on request

***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.

CHEMICAL COMPOSITION OF ALL WELD METAL

CANNOT BE DISCLOSED.

Note: Single Values shown above are maximum

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.

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