



STAINLESS STEEL WELDING ELECTRODES

RASI E 13 Cr



TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI 13 Cr is a basic coated electrode giving a deposit 13% Cr. of radiographic quality.

APPLICATIONS

Ideal for joining materials having similar alloy composition and for surfacing application in turbine parts, valve seals etc. Best suited for joining straight Chromium steels.

CLASSIFICATIONS

AWS : A5.4 E - 410-16

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.12%	®	Silicon - 0.9%
Manganese - 1%		Sulfur - 0.03%
Phosphorus - 0.03%		Cr - 11 - 13.5%
Ni - 0.70%		

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (MPa) - 450 Min.
ELONGATION % - 20 Min.

WELDING CURRENT : AC, DC(±)

Ø 2.50 mm - 50 - 75 Amps
Ø 3.15 mm - 80 - 100 Amps
Ø 4.00 mm - 110 - 140 Amps

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :-
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storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

*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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