



RASI HF 250R

HARD FACING WELDING ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI - HF 250 R design to give a hard and wear resistance deposit of approximate 250 brinell. The weld deposit which stand heavy impact load and has excellent resistance to rolling and sliding friction.

APPLICATIONS

RASI - HF 250 R the weld deposit is machinable and is used for surfacing / joining of gears, pinions, shafts, Couplings, Sugarcane crusher etc.

HARDNESS

HARDNESS ON TWO LAYER DEPOSIT 200 - 300 BHN

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.25%	Silicon - 0.6%
Manganese - 0.50%	Cr - 1 - 2 %

Note: Single Values shown above are maximum

PHYSICAL PROPERTIES

Machinability - GOOD
Abrasion Resistance - GOOD.
Impact Resistance - AVERAGE.

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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