

HARD FACING

RASI - HF 550 R

VERY POOR MACHINABLE DEPOSIT

CHARACTERISTICS :

RASI - HF 550 R Is a rutile coated AC/DC(-) electrode producing an air hardening type weld metal for hardfacing of carbon and alloy steels.

APPLICATIONS :

RASI - HF 550 R the weld deposit is Very Poor Machinable and is used for surfacing tractor rollers, Idlers in Steel mill, Cams, shear blades, sprockets, Break Shoes, forging Dies, Cement Die Rings, Crushing Hammers etc.

CHEMICAL COMPOSITION OF WELD METAL

ELEMENTS	C	Mn	Si	Cr
PERCENTAGE	0.45	1.00	1.00	6-7

Note : Single Values shown above are maximum

HARDNESS ON THREE LAYER DEPOSIT 450 - 550 BHN

WELDING CURRENT AND PACKING DATA : AC / DC(-)

Dia (mm)	2.5 x 350	3.15 x 450	4 x 450	5 x 450
Current (A)	50-70	100-120	140-180	180-220
Pices/Pkt	135	90	60	45
Pkts/Box	8	8	8	8

SUGGESTED WELDING PROCEDURE :

Confirm the Electrodes are absolutely dry as packed if exposed and damp heat them up to 150°C for 1/2 hrs and use.