

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -14

HYDROGEN CONTROLLED ELECTRODE FOR MILD, MEDIUM CARBON,
HIGH STRENGTH STEELS, CAST STEELS ETC.

CHARACTERISTICS

RASI WE - 14 is a hydrogen controlled electrode. Operates equally well in all conventional positions. High strength, high quality, radiographic welds are some of the special features.

APPLICATIONS

RASI WE - 14 is best suited for welding of mild, medium carbon, low carbon steels, cast steels, Truck chassis, Shovel booms, Pressure vessels, Heavy machinery parts, Parts subject to dynamic loads and impacts, heavy structural welding etc. Best suitable as a buffer layer before hardfacing.

TECHNICAL DATA

Ultimate Tensile Strength: 56 Kgf/mm²(Typical)

Elongation Percent: 26% (Typical)

CURRENT RANGE : AC/DC (+)

SIZE MM:	2.5	3.15	4.0	5.0
AMPS:	60-90	90-120	120-160	150-200

ALLOY BASIS : C, Mn, Si, Fe

PACKAGING

2 Kgs in one Plastic Carton and 10 Kgs in one Box.

STORAGE

Before using, confirm the electrodes are absolutely dry as packed. If exposed and damp, heat them to 300°C for one hour and use.