

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -16

AN UNIVERSAL ELECTRODE FOR JOINING OF ALL STEELS AND DISSIMILAR METALS

CHARACTERISTICS

RASI WE - 16 is a specially formulated Electrode for welding high strength steels and steels with unknown compositions. The weld deposit gives controlled ferrite-austenite structure providing high strength and toughness welds the excellent corrosion resistance. It operates equally well on AC as well as DC(+) in all conventional welding positions. Extremely low spatter and easily detachable slag.

APPLICATIONS

RASI WE - 16 Earth moving equipment parts, automobile springs and parts subjected to heat, corrosion and impact. For high strength sulphide/ Chloride corrosion applications like salt water pipe lines, re-building chemical agitator blade etc., It is ideally suited for high strength, crack free welds and overlays subject to services under wear, friction, impact, heat and corrosion. For joining & Surfacing of Mild & Low carbon steels, low alloy steels, spring steels, tool steels, die steels, stainless steels and "difficult" to weld steels and dissimilar steels.

TECHNICAL DATA

Ultimate Tensile Strength: 75-85 Kgf/mm²(Typical)

Elongation Percent: 22-25% (Typical)

Hardness : 230 BHN

CURRENT RANGE : AC/DC (+)

SIZE (MM) : 2.5 3.15 4.0 5.0

AMPS: 50-80 75-95 90-120 120-160

ALLOY BASIS : Fe, Cr, Ni, Mn

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 300C for one hour and use.