

RASI ULTRA-TECH

TECHNICAL SPECIFICATION SHEET

LOW HEAT INPUT WELDING ALLOYS

RASI WE -18

A CHROMIUM - NICKEL - MANGANESE ALLOY AUSTENITIC ELECTRODE FOR JOINING DISSIMILAR STEELS AND FOR BUTTERING LAYER APPLICATION.

CHARACTERISTICS

RASI WE- 18 is a stainless steel electrode depositing an austenitic alloy of chromium - Nickel - Manganese. The weld metal possesses high strength and superb toughness even at minus 100oC. Resists scaling upto 800oC work hardens under impact. Usable as a surfacing alloy for anti - wear properties. The electrode coating is carefully studied and chosen to achieve very low hydrogen level in the deposited alloy, easily disposable slag, finely rippled flat bead profile and low spatter.

APPLICATIONS

Joins high alloyed steel with mild steel or low alloy steels and welded joints between high manganese steel. As shock absorbing buffer on armour plate steels prior to surfacing with hard alloys. Anti - wear layer or rails, shunt points. The alloy workhardness to about 450BHN. The high manganese in the alloy enhances toughness while welding nickel based steels.

TECHNICAL DATA

Ultimate Tensile Strength: 640-660 N/mm²

Elongation: 35-39

As welded Hardness : 190-210 BHN

Work Hardened: 450 BHN

CURRENT RANGE : AC/DC (+)

SIZE MM: 2.5 3.15 4.0 5.0

AMPS: 60-70 80-120 110-150 150-200

ALLOY BASIS : C, Cr, Mo, Mn, 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 300oC for one hour and use.