

## RASI ULTRA-TECH

### TECHNICAL SPECIFICATION SHEET

#### LOW HEAT INPUT WELDING ALLOYS

#### RASI WE -63 Cr - Mn

A SUPERIOR ANTI WEAR AUSTENITIC MANGANESE STEEL ELECTRODE FOR PARTS SUBJECTED TO HEAVY WEAR AND IMPACT.

#### CHARACTERISTICS

RASI WE - 63 is a specially formulated electrode with Cr - Mn to give a better result in surfacing austenitic manganese steels. The electrode produces a weld which is work hardening and also exhibits resistance to cracking and deformation during working. It is characterised by excellent performance in all conventional positions, soft and stable arc which is easy to strike and restrike with good slag detachability and well rippled, uniform weld beads.

#### APPLICATIONS

The electrode is suitable for welding manganese steel parts, hardfacing of crushing equipments of all types excavator teeth, manganese Steel rails. Typical application includes surfacing and building up of broken or worn out manganese steel parts such as jaw and roll crusher, crusher hammers, excavator bucket teeth and lips, dredger bucket, dipper teeth rail road tracks, frogs and switches and similar machine parts and components subjected to heavy impact and high stresses.

#### TECHNICAL DATA

HARDNESS: As Welded Work hardened  
22-24 HRC 40-45 HRC

WELDING CURRENT : AC / DC (+)

SIZE MM:                3.15     4.00     5.00

CURRENT AMPS : 70-120 120-160 160-200

ALLOY BASIS : Mn, Ni, Cr, C, 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 up to 300C for one hour and use.

storage - Store in warm and dry place. If damped re dry at 100-110°C for 30 minutes.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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