

RASI ULTRA-TECH**TECHNICAL SPECIFICATION SHEET****LOW HEAT INPUT WELDING ALLOYS****RASI WE -64**

AN OUTSTANDING ELECTRODE WITH TOUGHNESS AND ABRASION RESISTANCE. IDEALLY SUITED FOR BUFFER LAYERS ON MANGANESE STEELS.

CHARACTERISTICS

RASI WE - 64 is a specially formulated electrode to give a better result in all positions for manganese steels. It is surface fusion alloy depositing chromium carbide Iron type weld metal which has excellent abrasion resistance under small impact loads. Suitable for multilayer build up where surface finish in a s - welded condition is acceptable. The electrode is suitable for depositing thick layers and the resultant weld is crack free.

APPLICATIONS

The wide range of applications of the electrode include welding and surfacing of 14% Manganese steels armour steels, carbon steels and the weld metal is work hardening type. Typical applications include surfacing mining machinery, dredgong equipments, excavator parts, mill hammers, cement mill air rings, crusher hammers, roll crushers, shovel tracks, coal mining cutters, tractor, grousers, dipper teeth, sand and pump impellers, valve seats etc.

TECHNICAL DATA

HARDNESS: As Welded Work hardened
23-25 HRC 50-55HRC

WELDING CURRENT : AC / DC (+)

SIZE MM: 3.15 4.00 5.00

CURRENT AMPS : 80-100 120-160 160-200

ALLOY BASIS : Fe, Mn, Cr, C.

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.