

RASI ULTRA-TECH**TECHNICAL SPECIFICATION SHEET****LOW HEAT INPUT WELDING ALLOYS****RASI WE -66**

OUTSTANDING LOW HEAT INPUT ELECTRODE FOR WELDING
NI - CR - MO ALLOYS AND FOR SURFACING APPLICATION..

CHARACTERISTICS

RASI WE - 66 is a heavy coated electrode with excellent welding characteristics. The weld deposit has excellent heat resistance, strength and toughness upto about 1000C and resistance to corrosion. ®

APPLICATIONS

RASI WE - 66 is ideally suited for welding Ni - Cr - Mo alloys to themselves. Fabrication and repair of hot pressing tools as well as surfacing of parts subject to abrasion, oxidation and corrosion. Also used for hot working tools. eg. Forging dies, heating elements, hot trimming dies, pump impellers, valves etc.

TECHNICAL DATA

Ultimate tensile Strength : 63 Kgf/mm²

Hardness as welded: 250 - 300 BHN

After Work Hardening : 450 BHN

Metal Recovery : 160%

CURRENT RANGE : AC / DC (+)

SIZE MM: 3.15 4.00 5.00

CURRENT AMPS : 90-130 130-170 170-210

ALLOY BASIS : Ni, Cr, Mo, W, 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 100c for one hour and use.