

**RASI ULTRA-TECH****TECHNICAL SPECIFICATION SHEET****LOW HEAT INPUT WELDING ALLOYS****RASI WE -69**

A SPECIAL ELECTRODE PRODUCING WELDS OF EXCEPTIONALLY HIGH RESISTANCE TO ABRASION AT ROOM TEMPERATURES AND AT ELEVATED TEMP.

**CHARACTERISTICS**

RASI WE - 69 is a surface fusion alloy depositing chromium carbide iron type weld metal which has excellent abrasion resistance under small impact loads, suitable for maximum of two layer build-up where surface finish is as welded condition is acceptable. It is specially designed for hardfacing applications on machine parts subject to severe erosion, abrasion and moderate impact.

**APPLICATIONS**

Hard surfacing of sand pump casing, pump impellers, cane knives, dozer blades, dredger cutters, screw conveyors, guides, slides. It is ideally suited for surfacing applications where resistance to erosion, heavy abrasion, with moderate impact, specially at elevated temperatures are important factors. The weld metal retains hardness upto 550oC and resistance to scaling upto 1000C.

**TECHNICAL DATA**

HARDNESS: 57-60 HRC

CURRENT RANGE : AC / DC (+)

SIZE MM:                    2.5     3.15     4.00     5.00

CURRENT AMPS : 55-80 80-100 110-150 150-180

ALLOY BASIS : Cr. Mn. 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 100cfor one hour and use.