

## RATNA13/4/05

### Special purpose basic coated Electrode of the depositing 13CR-4Ni-0.5Mo weld Metal.

**CLASSIFICATION** : AWS/SFA-5.4: E 410NiMoL-15

**APPROVAL** :

**CHARACTERISTICS** : A special purpose basic coated electrode for welding 13Cr, 4Ni, 0.5Mo deposition suitable for surfacing of steel casting, martensitic, ferrite chromium steel as well as steel of similar composition.

**APPLICATION** :

- 1) Surfacing of high pressure valves, turbine blades, guide vans and runners.
- 2) Pulp and paper plant equipments similar corrosion resisting chromium steel erosion.
- 3) Pitting and impact value.

**RE-DRY CONDITION** : Re-Dry the electrode at 250°C for 1 hrs before use.

#### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo
0.06 max.	1.00 Max	0.90 Max	0.030 Max	0.040 Max	11.00-12.50	4.00-5.00	0.40-0.70

#### ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	EL % (l=4d)
760-800	15-20

#### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-90	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	150-190	2	20

Customer packing on request.