RATNA 13CR

Basic coated, Hydrogen controlled stainless steel electrode for depositing a ferrite weld metal.

CLASSIFICATION : AWS/SFA-5.4: E 410-15, DIN E 13 MBP 20+120
IS-5206: E 13R 10

APPROVAL :

CHARACTERISTICS : A hydrogen controlled electrode for welding ferrite, martensitic chrome steels. Hardening effect can be avoided by pre-heating the job and later stress relieving process. An all position electrode, giving fine and rippled bead, easy slag removability. Weld deposit contain 13Cr.

APPLICATION :

1) Suitable for turbine construction, joining chrome steel, joining AISI 405, 410, 414, 420 stainless steel.
2) Welding of similar corrosion resistant chrome steels, steel casting, pump parts, components of oil refinery, coal washers, rebuilding of valves etc.
3) Machine parts, Gears, Fasteners, propeller shafts etc.

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
0.12 max.	1.00 Max	0.90 Max	0.030 Max	0.040 Max	11.00-13.5

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm^2)	EL % (l=4d)
520 Min.	20 Min.

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"	50-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-110	2	20
4.00 X 350	5/ 32" X14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	140-170	2	20

Customer packing on request.