

RATNA18/8/5

A basic coated austenitic stainless steel Electrode of the 18Cr-8Ni-6Mn.

CLASSIFICATION : AWS/SFA-5.4: E 307-16 (Nr.), DIN E 18 8 Mn B 20
IS-5206: E 18.8MnR 26

APPROVAL : RDSO

CHARACTERISTICS : A medium heavy coated austenitic stainless steel electrodes with stainless steel core wire give weld deposition of 18Cr-8Ni-5Mn and weld metal has excellent heat resistance up to 900°C and corrosion resistance from atmosphere, sea water and weak acids.

APPLICATION :

- 1) It is easy to operate in all position at low currents and for joining and surfacing applications to enhance resistance to impact and abrasion and also for buffer layers on variety of steels.
- 2) Specially designed for joining ferrite to austenitic steels, armour plates, austenitic Manganese steels (12% Mn), Heat Resistance steels, dissimilar materials for buffer layers 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	Ni
0.14 max.	5.00-8.00	1.00 Max	0.030 Max	0.040 Max	18.00-21.50	9.00-10.70

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT	HARDNESS
590-670	30-40	+20 ⁰ C : 80-120 J	AS WELDED 200 BHN AS WORK 500 BHN

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"	75-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	150-180	2	20

Customer packing on request.