

## RATNA 20/25/5 Cu

### Special type Electrode fully Austenitic, extra-low carbon weld metal Mo & Cu.

**CLASSIFICATION** : AWS/SFA-5.4: E 385-16  
DIN E 20 25 5 Cu R 26

**APPROVAL** :

**CHARACTERISTICS** : Ratna 20/25/5 Cu is special type electrode producing an extra low carbon weld metal containing 20Cr-25Ni-5Mo-2Cu. The weld metal exhibits excellent corrosion resistance to sulphuric acid, phosphoric acid, acetic acid, formic acid, fatty acids, oxalic acid etc.

**APPLICATION** :

- 1) Ideally suited for welding carpenter 20, HV 9, HV 9A, Uranus B-6, UHB 904L, sandvik 2Rk65 and other similar materials.
- 2) Electrode may be used to joint type 317L material where improved corrosion resistance is needed.

**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	Cu
0.03 max.	1.00-2.50	0.90 Max	0.020 Max	0.020 Max	19.50-21.50	24.00-26.00	4.20-5.20	1.20-2.00

#### ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20°C : 60-100 J
520-690	30-45	

#### 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"	60-80	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"	150-180	2	20

Customer packing on request.