

RATNA 2093L

A rutile based, all position stainless steel Electrode for welding Duplex stainless steels.

CLASSIFICATION : AWS/SFA-5.4: E 2209-16
DIN E 22 9 3 LR 23

APPROVAL :

CHARACTERISTICS : Ratna 2093L is medium heavy coated, all position electrodes depositing "duplex" micro structure, consisting of a ferrite matrix, a stainless steel requirement of armour steel. Weld metal has excellent corrosion resistance especially to atmosphere, sea wear and weak acids.

APPLICATION :

- 1) To join stainless to carbon steel, for depositing austenitic weld metal on higher carbon steel, armour steel etc.
- 2) Weld metal deposited by electrodes combines increase tensile strength and resistance to pitting corrosion attack and to stress corrosion cracking for satisfaction services.

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	N
0.04 max.	0.50-2.00	1.00 Max	0.030 Max	0.040 Max	21.00-23.50	8.50-10.50	2.50-3.50	0.080- 0.20

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20°C : 40-80 J
690-850	20-30	

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"	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.