

# RATNA 2553

Specially designed electrode welding for Super Duplex Stainless steel.

**CLASSIFICATION** : AWS/SFA-5.4: E 2553-16  
BS 2526 25.6.2Cu.R

**APPROVAL** :

**CHARACTERISTICS** : Lime- Titania covering to derive the advantage of pleasing operating characteristics on DC (+) as well as AC (70V) current. Electrode for the welding of super duplex stainless steel of similar composition and containing of Cupper. Control of weld metal chemistry for the achieving the desired level of ferrite and high resistance general, pitting and stress corrosion.

**APPLICATION** :

Mostly castings materials to be welded, such as ASTM A351, A744 (CD4MCu), UNS 393370, ASTM A 240 (wrought ), UNS 532550, BS 3146-ANC 21, BS 3100 332 C13, Proprietary alloys: Creusot Uranus 55, 50M APV Lake and Elliot DPH, Langley alloys Ferralium Suitable for pumps, valves, process equipment in offshore oil & Gas industries, pulp & paper, textile industries , chemical and petrochemical plants,.

**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	Cu	Mo	N
0.06 max	0.50- 1.50	1.00 Max	0.030 Max	0.040 Max	24.00- 27.00	6.50- 8.50	1.5- 2.50	2.90 3.90	0.10- 0.25

## ALL WELD MECHANICAL PROPERTIES (As Welded):

YS (0.2% ) (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=5d)	Impact Values ( J @+20°C )	Hardness (BHN)
550 Min.	760 Min.	15 Min.	30-50	250-300

## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	Kg/packet.	Kg/case.
2.50/ 2.40 X 350	3/ 32" X 14"	70-100	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	90-120	2	20
4.00 X 350	5/ 32" X 14"	120-160	2	20
5.00 X 350	3/ 16" X 14"	160-200	2	20

Customer packing on request.