

RATNA 308

All position stainless steel Electrode welding for maximum resistance to cracking and corrosion.

CLASSIFICATION : AWS/SFA-5.4: E 308-16 , DIN E 199R26
IS-5206: E 19.9R 26 , BS 19.9R

APPROVAL : RDSO

CHARACTERISTICS : Stainless steel electrode with properties like oxidation and corrosion resistance, resistance to cracking. The weld deposit has excellent strength and is of radiographic quality. The electrode gives smooth finish, spatter free and self peeling slag.

APPLICATION :

- 1) Suitable for joining AISI 301, 302, 304 and 308 steel having 18Cr/8Ni and similar composition.
- 2) German steel Nos. 4016,4501, 4300, 4301 on continental steel V2A.
- 3) Steels of difficult weldability such as certain grade of Armour steel.

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
0.080 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	18.00-21.00	9.00-11.00

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20°C : 60-80 J	FERRITE (FN)
550-660	35-45		3-10

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.00 X 300	5/ 64" X 12"	40-60	1.5	15
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.