

RATNA 310

Rutile type 25Cr/20Ni fully austenitic stainless steel electrode.

CLASSIFICATION : AWS/SFA-5.4: E 310-16, DIN 25 20 B 20
IS-5206: E 25.20R 26 , BS 25 20 R

APPROVAL :

CHARACTERISTICS : A rutile type all position electrode made of core wire 25Cr/20Ni to have deposits of 25Cr/20Ni. The electrode is specially designed for oxidation and scaling resistance at elevated temperatures at 1200°C with excellent weld metal finish, low spatter and easily removable slag deposit.

APPLICATION :

- 1) Suitable for weld AISI 310 type steel and DIN Nr. 1.4848,1.4841,1.4845 .
- 2) German steels like 4762,4828,4841,4846 and 4848.
- 3) Clad side of clad steels.
- 4) High temperature furnace part.
- 5) Gas turbine combustion chambers.
- 6) Hardenable steel and dissimilar steels.

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
0.08-0.20	1.00-2.50	0.75 Max	0.030 Max	0.040 Max	25.00-28.00	20.00-22.50

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT	FERRITE (FN)
550-660	30-40	+20 ⁰ C : 60-90 J	Nil

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC70 V) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-90	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-110	2	20
4.00 X 350	5/ 32" X 14"	100-135	2	20
5.00 X 350	3/ 16" X 14"	140-180	2	20

Customer packing on request.