

## RATNA 36Cb

**Ferrite controlled, low carbon, 18/13/2.3 Mo with Nb stainless steel Electrode.**

**CLASSIFICATION** : AWS/SFA-5.4: E 318-16 , DIN E 19 123 Nb R23  
IS-5206: E 19.12.2NbR 26

**APPROVAL** :

**CHARACTERISTICS** : A ferrite controlled, low carbon, 18/13/2.3 Mo with Nb electrode. Weld deposit is resistant to inter granular corrosion cracking, resistant to pitting. The electrode gives smooth arc, fine and rippled bead appearance and easy slag detachability.

**APPLICATION** :

- 1) Suitable to weld Niobium and Titanium based stainless steels.
- 2) Maximum resistance to cracking, corrosion and scaling.
- 3) Stabilized with Niobium to resist intergranular corrosion between 425°C and 845°C.

**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	Cb
0.08 max.	0.50- 2.50	1.00 Max	0.030 Max	0.040 Max	17.00-20.00	11.00-14.00	2.00-3.00	6xC Min -1.00 Max

### ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT	FERRITE (FN)
550-660	25-40	+20°C : 60-80 J	5-9

### 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"	50-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-100	2	20
4.00 X 350	5/ 32" X 14"	100-140	2	20
5.00 X 350	3/ 16" X 14"	140-180	2	20

Customer packing on request.