

## RATNA 8045 P2 H4R

**Specifically designed for high strength pipe welding vertical down position.**

**CLASSIFICATION** : AWS/SFA-5.5: E 8045 P2 H4R

**APPROVAL** :

**CHARACTERISTICS** : Low hydrogen type, moisture resistant electrode have specifically been designed for the welding of hot, fill, and cap passes in high strength pipe butt joints using vertical downward progression. This electrode is not recommended for welding with vertical upward position. These electrode not recommended for the root pass ( stringer bead ) on open gaps.

**APPLICATION** :

1. Welding of high strength API 5L pipe steels.
2. welding suitable for other high strength, medium and high carbon and low alloy steels.
3. Hot tapping and Pipe repairing

**RE-DRY CONDITION** : No need of drying. The electrodes are vacuum packed hence can be used straight on the job.

**Hydrogen content of the weld metal when measured in accordance with AWS/ANSI 4.3-86 specification.** : 4ml/100g max.  
Typical : 2.50 ml/ 100 g weld metal

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S&P	Ni	Cr	Mo	V
0.12 max.	0.90-1.70	0.80 Max.	0.030 Max	1.00 Max.	0.20 Max	0.50 Max.	0.050 Max.

### ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
460 Min.	550 min.	19 min.	Minus 30 <sup>0</sup> C : 80 J Min.

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+) Amps	Kgs/pkt.	Kgs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	90-120	5	20
3.15/ 3.20 X 350	1/ 8" X 14"	120-170	5	20
4.00 X 350	5/ 32" X 14"	170-230	5	20

Customer packing on request.