

RATNA CR 2

Hydrogen controlled iron powder Electrode for welding Creep-Resistant 2Cr-1Mo steels.

CLASSIFICATION : AWS/SFA-5.5: E 9018 B3
IS-1395: E63 BB 326Fe

APPROVAL :

CHARACTERISTICS : A medium heavy coated, hydrogen controlled, iron powder type, all position radiographic quality electrode to weld 2.25% Cr-1.00% Mo steel, having increased working efficiency. Electrode has properties of creep resistance up to 575°C.

APPLICATION :

- 1) Suitable to weld high tensile.
- 2) Low alloy steels with 2.25% Cr and 1% Mo used in oil refinery/ power plants, steam boilers.
- 3) Equipments subjected at high temperatures in synthetic chemical units.
- 4) Repairs of cast steel components.
- 5) Parts of automobiles / earthmoving machineries.
- 6) Includes marine applications.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Mo	S&P
0.05-0.12	0.90 Max	0.60 max	2.00-2.50	0.90-1.20	0.030 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)
530-630	620-700	20-25

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	170	640
3.15/ 3.20 X 450	1/ 8" X 18"	100-140	110	440
4.00 X 450	5/ 32" X 18"	140-180	72	288
5.00 X 450	3/ 16" X 18"	190-240	50	200

Customer packing on request.

