

RATNA GT

Specially designed for Galvanizing Baths

CLASSIFICATION : IS : ES4122 DIN : E 4300 A525

APPROVAL :

CHARACTERISTICS : Ratna GT is a special purpose electrode , specially designed for welding of Hot-dip galvanizing baths. Weld metal is highly resistance to molten zinc corrosion. Electrode is further characterized by soft arc, low spatter and easily detachable slag.

APPLICATION : Typical applications include welding of plates for fabrication of galvanizing baths, filling up of worn-out body of galvanizing bath to resist molten zinc corrosion, window frames, thin walled tanks and vessels **etc.**

RE-DRY CONDITION : Re-Dry the electrode at 150°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION % (TYPICAL) :

C	Mn	Si	S	P
0.050	0.30	0.050	0.015	0.018

ALL WELD MECHANICAL PROPERTIES (TYPICAL) :

UTS (N/mm ²)	EL % (l=4d)
450	30

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC-/AC) Amps	kg/packet.	kg/case.
3.15/ 3.20 X 350	1/ 8" X 14"	75-100	5	20
4.00 X 450	5/ 32" X 18"	110-140	6	24
5.00 X 450	3/ 16" X 18"	150-180	6	24

Customer packing on request.