

RATNA HF1

Medium heavy coated, air hardening, rutile type Electrode.

CLASSIFICATION : DIN-8555: E1 –UM-250

APPROVAL :

CHARACTERISTICS : A medium heavy coated, air hardening, rutile type electrode for hard facing on mild steel and low alloy steels, weld deposits are normally machinable, recommended to use RATNA 7016 as buffer layer while working on hard base materials. Gives moderate toughness and hardness.

APPLICATION :

- 1) Suitable to use hammers, pinion teeth's.
- 2) Railway and tram rails.
- 3) Gear shaft couplings, axels, cane crushers, machine parts.
- 4) Where toughness and hardness is desired with machinable properties.
- 5) Rollers, Sugarcane crushers, pulleys, sprockets etc.

RE-DRY CONDITION : Re-Dry the electrode at 120°C for 30-60 minutes, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr
0.25 max.	0.60 Max	0.60 max	1.50-2.50

WELD METAL HARDNESS:

Hardness
200-300 BHN

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC- AC) Amps	No. of Pcs./pkt.	No. of Pcs./Case
3.15/ 3.20 X 450	1/ 8" X 18"	100-120	155	620
4.00 X 450	5/ 32" X 18"	140-170	98	392
5.00 X 450	3/ 16" X 18"	190-220	62	248

Customer packing on request.