

RATNA HF 2

Medium heavy coated, air hardening, rutile type Electrode.

CLASSIFICATION : DIN-8555: E1 –UM-400

APPROVAL :

CHARACTERISTICS : A medium heavy coated, air hardening, rutile type electrode for overlaying hard surface on mild steel and low alloy carbon steel, weld deposit is non machinable type, recommended to use RATNA 7016 as buffer layer while working on hard base material. Gives resistance to abrasion and toughness.

APPLICATION :

- 1) Suitable to use on couplings.
- 2) Break shoes, cams, gears, cogwheels, crawler parts, shafts, plough shears.
- 3) Blades and components where abrasion resistance coupled with toughness is required.

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
0.20-0.40	0.60 Max	0.60 max	2.50-3.50

WELD METAL HARDNESS:

Hardness
350-400 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"	100-130	155	620
4.00 X 450	5/ 32" X 18"	140-180	98	392
5.00 X 450	3/ 16" X 18"	180-220	62	248

Customer packing on request.