

RATNAHFLH

Hydrogen controlled, Iron powder type Electrode for versatile Applications.

CLASSIFICATION : DIN-8555: E2 –UM-60-S

APPROVAL :

CHARACTERISTICS : A medium heavy coated hydrogen controlled, iron powder, air hardening type hard facing electrode with weld deposits are hard and cannot be machined. Weld dressing is possible by grinding, can withstand friction and moderate impact.

APPLICATION :

- 1) Suitable to work on high carbon and high sulphur steels without cracks.
- 2) Crane wheels, drill bits, crusher hammers, shear blades, rock drill cane cutting knives.
- 3) Impellers, oil expeller worms, conveyor buckets, spockets etc.
- 4) Unique in its versatility of applications in areas of building-up worn out parts and hardfacing.

RE-DRY CONDITION : Re-Dry the electrode at 250°C-300°C for 1 hour,

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Mo	V
0.50-0.80	1.00 Max	0.75 max	6.00-8.00	0.40-0.60	0.20-0.40

WELD METAL HARDNESS:

Hardness
550-650 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	115	460
4.00 X 450	5/ 32" X 18"	150-180	75	300
5.00 X 450	3/ 16" X 18"	210-260	57	228

Customer packing on request.