RATNA HT 60

Basic type, medium heavy coated, Hydrogen controlled iron powder type Electrode for Cr-Mo-V low alloy steel.

CLASSIFICATION : AWS/SFA-5.5: E 9018 G
IS-1395: E 63 BG 129Fe

CHARACTERISTICS : Basic type, iron powder, hydrogen controlled medium heavy coated electrode producing 1.5 Cr 1.0% Mo and 0.2 V weld deposit. Electrode has high welding efficiency coupled with creep resistance properties at high temperature and has excellent mechanical properties.

APPLICATION :

1) Suitable for high pressure boiler tubes and plates.
2) Fabrication for welding Cr-Mo-V steels used for elevated temperature services up to 600°C.
3) Suitable for fine grained and creep resistant steel welding.
4) Suitable for steel, thermal and chemical plants.

RE-DRY CONDITION : Re-Dry the electrode at 250°C-300°C for one hour, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Mo	V	P	S
0.07-0.12	0.90 max	0.60 max	1.20-1.50	0.40 max	0.90-1.10	0.15-0.25	0.030 max	0.030 max

ALL WELD MECHANICAL PROPERTIES (AS WELDED):

YS(0.2% offset) (N/mm^2)	UTS (N/mm^2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
650 Min	800 Min	10 Min	$+27^0$C : 20 J (Min.)

ALL WELD MECHANICAL PROPERTIES (PWHT 690°C/8 hrs.):

YS(0.2% offset) (N/mm^2)	UTS (N/mm^2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
600 Min	700 Min	16 Min	$+27^0$C : 70 J (Min.)

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	70-100	170	680
3.15/ 3.20 X 450	1/ 8" X 18"	100-140	110	440
4.00 X 450	5/ 32" X 18"	140-190	72	288
5.00 X 450	3/ 16" X 18"	200-250	50	200

Customer packing on request