

RATNA HT65 spl

Basic coated, Hydrogen controlled iron powder type Electrode for high tensile steels.

CLASSIFICATION : AWS/SFA-5.5: E 9018M
IS-1395: E 63 BM 129Fe

APPROVAL :

CHARACTERISTICS : A hydrogen controlled, iron powder electrode for welding high tensile structural steels. It gives smooth arc, low spatter, easy slag detachability, medium penetration and welded joints are of radiographic quality and weld metal exhibits high impact values at sub-zero temperatures..

APPLICATION :

- 1) pressure vessels.
- 2) chemical plants and machinery parts.
- 3) Equipment such as penstocks to be subjected to -50°C.
- 4) Heavy earthmoving machinery, fabrication.
- 5) Automobile parts.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs before use

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Mo	Cr	S&P
0.10 max.	0.80-1.25	0.60 max	1.40-1.80	0.35 Max	0.15 Max.	0.030 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
520-630	620-700	24-28	-50°C : 30-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 70V)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	80-100	170	640
3.15/ 3.20 X 450	1/ 8" X 14"/ 18"	100-140	105	420
4.00 X 450	5/ 32" X 18"	140-180	70	280
5.00 X 450	3/ 16" X 18"	200-250	48	192

Customer packing on request.