

# RATNA HT65 D1

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

**CLASSIFICATION** : AWS/SFA-5.5: E 9018D1  
IS-1395: E 63 BD126

**APPROVAL** :

**CHARACTERISTICS** : A hydrogen controlled, iron powder electrode for welding high tensile structural steels with good toughness down to -50°C. It gives smooth arc, low spatter, easy slag detachability, medium penetration and welded joints are of radiographic quality.

**APPLICATION** :

- 1) suitable for Welding HSLA steels.
- 2) suitable for welding of "CONCOR" wagon type application of the Indian Railways.
- 3) Suitable for welding penstocks, Tanks, Pressure Vessels and Bridges
- 4) Suitable for welding of high strength low alloy steels, Grain refined steels.
- 5) Quenched and tempered steels.

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

**DIFFUSIBLE HYDROGEN** : 5ml/ 100 grams Weld Metal.

## ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Mo	S	P
0.12 max.	1.0-1.75	0.80 max	0.90 Max	0.25-0.45	0.030 Max.	0.030 Max.

## ALL WELD MECHANICAL PROPERTIES:

( After SR, at 620°C±15 °C for one hour )

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
560-640	640-720	20-26	-50 <sup>0</sup> 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	165	660
3.15/ 3.20 X 450	1/ 8" X 14"/ 18"	110-140	110	440
4.00 X 450	5/ 32" X 18"	150-190	75	300
5.00 X 450	3/ 16" X 18"	190-250	55	220

Customer packing on request.