RATNA HT Spl

Basic coated, extra low hydrogen controlled low alloyed high tensile steel Electrode.

CLASSIFICATION : AWS/SFA-5.5: E 11018 M
IS-1395: E76 BM 329Fe

APPROVAL :

CHARACTERISTICS : A basic coated extra low hydrogen controlled, low alloyed high tensile steel electrode. The weld metal possesses excellent strength coupled with toughness. Electrode is of radiographic quality, gives low spatter, fine bead appearance. Slag detachability is easy.

APPLICATION :

1) welding of high tensile strength steels (800 N/mm2) such as USS-1 & WEL-TEN 80 and steels conforming to ASTM A517.

2) High strength coupled with impact resistance strength at sub-zero temperature service weld joints.

3) Earthmoving machinery, heavy structure made of high tensile steels, penstocks.

4) Extra hydrogen control ensures resistance to hydrogen induced cracking onsite conditions.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Mo
0.10 max.	1.30-1.80	0.60 max	0.40 Max	1.25-2.50	0.25-0.50

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm^2)	UTS (N/mm^2)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
680-770	760-850	20-26	-50^0C : 30 -60 J

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"	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"	180-250	48	192

Customer packing on request.