

RATNA HT65

Low Hydrogen basic coated iron powder type Electrode for welding Q&T steels.

CLASSIFICATION : AWS/SFA-5.5: E 9016G
IS-1395: E 63 BG 129Fe

APPROVAL :

CHARACTERISTICS : Low hydrogen basic coated iron powder electrode for welding Q&T steels. It gives radiographic quality weld metal. Welding suitable for all positions with smooth arc and low spatter. Good toughness properties with high tensile strength.

APPLICATION :

- 1) suitable for welding high tensile steels..
- 2) Q & T steels, HSLA steels.
- 3) penstocks, tanks, pressure vessels and bridges.
- 4) Earthmoving machinery and similar heavy fabrications.
- 5)

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

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Mo	S&P
0.10 max.	1.20-1.50	0.60 max	0.80-1.50	0.60 Max	0.030 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
530-640	620-690	17-26	-50 ⁰ 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"	70-100	165	660
3.15/ 3.20 X 450	1/ 8" X 14" / 18"	100-130	110	440
4.00 X 450	5/ 32" X 18"	150-180	75	300
5.00 X 450	3/ 16" X 18"	190-230	55	220

Customer packing on request.