

RATNA HT 75-D2

Medium heavy coated, Hydrogen controlled iron powder Electrode.

CLASSIFICATION : AWS/SFA-5.5: E 10018-D2
IS-1395: E 68 BG 126Fe

APPROVAL :

CHARACTERISTICS : A medium heavy coated, hydrogen controlled, iron powder electrode to be used in all position. Gives excellent operating characteristics coupled with least spatter, having properties to resist hydrogen embrittled cracking. Weld deposit is of radiographic quality.

APPLICATION :

- 1) Suitable for welding Quenched & Tempered steels.
- 2) welding of High tensile steels.
- 3) Machinery components of heavy earthmoving equipment and road building.
- 4) Casting where strength coupled with toughness is called for.
- 5) Off-shore constructions and machinery, penstocks, pressure vessels, bridges and submarines.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hrs.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Mo
0.15 max.	1.65-2.00	0.80 max	0.30 Max	0.90 Max	0.25-0.45

ALL WELD MECHANICAL PROPERTIES:(PWHT 620°C/1Hrs)

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
600 Min	690 Min	16 Min.	-50 ⁰ C : 27-60 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.