

RATNA 8016-C2

A Basic Coated 3.50% Ni Alloyed Electrode for Welding Low Alloy Steels.

CLASSIFICATION : AWS/SFA 5.5 E 8016-C2

CHARACTERISTICS :

A basic coated hydrogen controlled electrode depositing weld metal which contain 3.0-3.5 % Nickel. The electrodes have smooth and stable arc characteristic with easy slag removal system. The other features are excellent striking and good bead appearance. The weld metal is of radiographic quality. This type of electrodes to be used for low temperature service.

APPLICATION :

Specially designed for welding fine grained steels and nickel steels for service temperatures down to minus 80°C. Other application include pressure vessels & storage tanks etc.

RE-DRY CONDITION : Re-Dry the electrode at 300°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	S	P
0.12	1.25	0.60	3.00-3.75	0.030	0.030

(Single value maximum)

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	Elongation %	CHARPY "V" NOTCH IMPACT AT
460 min.	550 min.	19 min.	-75°C : 27 J min.

(PWHT 605^o±15^oC for 1 Hrs.)

DIEMENSION, CURRENT CONDITION & PACKING DATA:

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/AC 70V)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/2.40	3/32"	70-100	170	640
3.15/3.20	1/8"	100-130	110	440
4.00	5/32"	150-180	70	280
5.00	3/16"	190-230	48	192

Tailor made packing available on request.