

RATNA CR5

Hydrogen controlled iron powder Electrode for welding Creep-Resistant 5Cr-0.5Mo steels.

CLASSIFICATION : AWS/SFA-5.5: E 8018 B6
IS-1395: E41 BB 626Fe

APPROVAL :

CHARACTERISTICS : A medium coated, hydrogen controlled, iron powder type electrode, producing 5% Cr-0.5% Mo deposit. Weld deposit is of radiographic quality, highly resist to corrosion, oxidation and exhibits creep resistance property at elevated temp. up to 550°C. The finish is excellent.

APPLICATION :

- 1) Ideally suitable for oil refinery.
- 2) Petrochemical industries, chemical industries.
- 3) Power house applications where steels of similar compositions are used.

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

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Mo
0.05-0.12	1.00 Max	0.60 max	0.030 Max	0.030 Max	4.00-6.00	0.45-0.65

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)
460-560	550-680	20-28

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+) Amps	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 18"	100-130	110	440
4.00 X 450	5/ 32" X 18"	140-180	75	300
5.00 X 450	3/ 16" X 18"	180-240	55	220

Customer packing on request.