

RATNA HT

Basic type, medium heavy coated, Hydrogen controlled iron powder type Electrode.

CLASSIFICATION : AWS/SFA-5.5: E 9018 G
IS-1395: E 63 BG 129Fe

APPROVAL :

CHARACTERISTICS : A basic type, medium heavy coated, hydrogen controlled, iron powder electrode for welding high tensile structural steel, heavy section, restrained joints in high tensile steels. It gives smooth arc, low spatter, easy slag detachability, medium penetration and welded joints are of radiographic quality.

APPLICATION :

- 1) Suitable for welding high tensile steels.
- 2) Oil refinery components, structural fabrication.
- 3) Equipment such as penstocks to be subjected to -50°C.
- 4) Boiler fabrication, heavy earthmoving machinery, fabrication.
- 5) Power house construction and for welding Q & T steels/ HSLA steels.

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.	1.20-1.80	0.50 max	0.80-1.50	0.60 Max	0.025 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
530-630	620-700	17-24	-50°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.