

# RATNA HT75

## Medium heavy coated, Hydrogen controlled iron powder Electrode.

**CLASSIFICATION** : AWS/SFA-5.5: E 10016 G  
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 250°C for 1 hrs.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Mo
0.10 max.	1.20-1.60	0.60 max	0.30 Max	1.50-2.50	0.20-0.40

### ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
600-690	690-770	20-26	-50 <sup>0</sup> 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	165	660
3.15/ 3.20 X 450	1/ 8" X 14"/ 18"	100-140	110	440
4.00 X 450	5/ 32" X 18"	140-190	75	300
5.00 X 450	3/ 16" X 18"	200-240	55	220

Customer packing on request.