

## RATNA-8016 (Ni) spl

**Basic coated low Hydrogen type High Tensile Electrode for low temperature service.**

**CLASSIFICATION** : AWS/SFA-5.5: E 8016-G  
IS-1395: E 55BG 129Fe

**APPROVAL** :

**CHARACTERISTICS** : A medium-heavy coated all position basic type of hydrogen controlled electrode for the welding of mild steel, medium high tensile and low alloy steels and for joining cast steel to mild steel. Gives sound radiographic quality welds having excellent mechanical properties. The electrode gives good penetration, strong arc, easily detachable slag and smooth uniform weld-bead.

**APPLICATION** :

- 1) Joining Class III and IV steels.
- 2) Repair of cast iron components (pre-heat necessary for large parts.)
- 3) Joining mild steel to cast iron.
- 4) Fabrication of boilers, pressure vessels, oil tanks.
- 5) Shipbuilding.

**RE-DRY CONDITION** : Re-Dry the electrode at 300°C for 1 hrs, for best results.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Ni
0.10 max.	1.0-1.70	0.30-0.85	0.030 Max	0.030 Max	1.00 Max

### ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4xd)	CHARPY "V" NOTCH IMPACT AT
470-590	590-690	20-24	Minus 40 <sup>0</sup> C : 60 J (avg.)

### 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"	70-110	165	660
3.15/ 3.20 X 450	1/ 8" X 14"/ 18"	95-130	110	440
4.00 X 450	5/ 32" X 18"	130-170	80	320
5.00 X 450	3/ 16" X 18"	180-250	65	260

Customer packing on request.