

R-195M

A basic coated austenitic stainless steel Electrode of the 18Cr-8Ni-6Mn

Basis OF Alloys : C, Si, Mn, Cr, Ni, Mo

Application & Descriptions : R-195M is specially designed austenite stainless steel work hardening low heat input type welding electrodes. Weld metal is crack proof, tough and resistant to abrasion and deformation. Resistant to scaling up to 850°C.

Suitable for welding austenitic manganese steel, medium carbon and alloyed steels. Also ideal as cushion layer and for joining dissimilar steels such as austenitic manganese steel to ferrite steels. Typical applications include track rollers, sprocket wheels, crusher hammers, overhead gantry tracks, earth moving machinery parts, crossing and joints, mining and cement industries machinery parts.

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hour,

ALL WELD MECHENICAL PROPERIES (TYPICAL):

UTS	Elongation	HARDNESS
650 N/mm ²	35%	AS WELDED 200 BHN AS WORK 500 BHN

DIEMENSION, CURRENT CONDITION & PACKING DATA:

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/- AC) Amps	weight of packet (Kgs)	Weight of Case
2.50x350mm	3/32"X14"	50-80	2	20
3.20x350	1/8"X14"	70-110	2	20
4.00x350	5/32"X14"	100-130	2	20
5.00X350	3/16"X14"	130-160	2	20

Customer packing on request.