

RATNA 17CR

Heavy coated, all position type Electrode depositing 17Cr weld Metal.

CLASSIFICATION : AWS/SFA-5.4: E 430-15
IS-5206: E 17R 10

APPROVAL :

CHARACTERISTICS : An all position, hydrogen controlled electrode specially designed to join AISI 430 grade stainless steels. Weld deposit exhibits 17 Cr deposit and is of radiographic quality. The bead is fine and rippled in appearance. Welded joints should undergo post and pre heat treatment to achieve desired properties.

APPLICATION :

- 1) Suitable for welding AISI 430 & 431 stainless steels and steels with higher or lower chromium content.
- 2) Surfacing of impellers, turbine blades, corrosion and heat resistance applications.

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
0.10 max.	1.00 Max	0.90 Max	0.030 Max	0.040 Max	15.00-18

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)
450 Min	20 Min

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-110	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	140-170	2	20

Customer packing on request.