

# RATNA HF5

**Hydrogen controlled hardfacing Electrode with resistance to abrasion and friction between metal to metal wear .**

**CLASSIFICATION** : DIN-8555: E1 –UM-60GR

**APPROVAL** :

**CHARACTERISTICS** : A hydrogen controlled, medium heavy coated hardfacing electrode with resistance to abrasion and friction between metal to metal. The electrode gives smooth arc, low spatter, easy welding operation characteristics.

**APPLICATION** :

- 1) Suitable for resurfacing on mixer blades worms of oil expellers.
- 2) Screw conveyors, shears, bucket tips and excavators teeths.

**RE-DRY CONDITION** : Re-Dry the electrode at 250°C for 1 hour before use.

## ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr
2.00-3.00	0.80-1.25 Max	2.50-3.50	2.50-3.50

## WELD METAL HARDNESS:

Hardness
600 BHN Avg.

## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/ AC) Amps	No. of Pcs./pkt.	No. of Pcs./Case
3.15/ 3.20 X 450	1/ 8" X 18"	90-120	132	528
4.00 X 450	5/ 32" X 18"	120-160	100	400
5.00 X 450	3/ 16" X 18"	160-200	65	260

Customer packing on request.