

# RATNA IILH

## Basic coated low Hydrogen type Hard facing Electrode

**CLASSIFICATION** : DIN-8555: E1 -UM-400-S

**APPROVAL** :

**CHARACTERISTICS** : A medium-heavy coated hydrogen controlled electrode for hard facing applications on mild steel, carbon steel and low alloy steel where approximately 300 Brinell hardness is required. The weld deposit is machinable with carbide tools.

**APPLICATION** :

- 1) Suitable to weld on rail ends and crossing.
- 2) Plough shares, shear plades, brake shoes, cogwheels.
- 3) Conveyer parts, cold punching dies, pulleys and steel casting etc.

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

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr
0.20-0.40	1.00 Max	0.60 max	2.50-3.50

### WELD METAL HARDNESS:

Hardness
350-400 BHN

### 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"	100-140	115	460
4.00 X 450	5/ 32" X 18"	140-180	75	300
5.00 X 450	3/ 16" X 18"	190-230	57	228

Customer packing on request.