

## RATNA HF 3

**Air hardening type Electrode for resistant to severe abrasion and moderate Impact.**

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

**APPROVAL** :

**CHARACTERISTICS** : A medium heavy coated, air hardening electrode for overlaying hard surface on mild steel and low alloy carbon steel, deposits are non machinable and can only ground. It is best suited for abrasion and impact or both together in service. Use RATNA 18/8/5 or RATNA 7016 as buffer layer on austenitic/ carbon steel.

**APPLICATION** :

- 1) Mine rails, dredger bucket lips, plough shares.
- 2) Crusher hammers, drilling bits.
- 3) Bamboo and cane cutting knives, conveyor buckets, crane wheels, oil expeller etc..

**RE-DRY CONDITION** : Re-Dry the electrode at 120°C for 30-60 minutes, for best results.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr
0.40-0.70 max.	0.60 Max	0.60 max	5.00-8.00

### 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	155	620
4.00 X 450	5/ 32" X 18"	145-175	98	392
5.00 X450	3/ 16" X 18"	180-210	62	248

Customer packing on request.