

## Ratna HF 3

### CLASSIFICATION

- DIN-8555 E1 -UM-60
- 2560-A E 42 3 C 15

### APPLICATIONS

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

### DESCRIPTION

- 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.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)			
CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	CHROMIUM (CR)
0.40-0.70 MAX	0.60 MAX	0.60 MAX	5.00-8.00

CURRENT POLARITY	WELDING POSITION
DC(-), AC	FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)
HARDNESS (BHN)
AVG. 600 BHN

SIZE AND CURRENT RECOMMENDATIONS		
SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC-, AC
3.2mm x 350mm	1/8" x 14"	90-120
4.0mm x 350mm	5/32" x 14"	145-175

### RE-DRY CONDITIONS

- Re-dry the electrode at 120°C for 30-60 minutes, for best results.

NOTE:  
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