

## Ratna HF II LH

### CLASSIFICATION

- DIN-8555 E1 -UM-400-S

### APPLICATIONS

- Suitable to weld on rail ends and crossing.
- Plough shears, shear blades, brake shoes, cogwheels.
- Conveyer parts, cold punching dies, pulleys and steel casting etc.

### DESCRIPTION

- 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.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)			
CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	CHROMIUM (CR)
0.20-0.40	1.00 MAX	0.60 MAX	2.50-3.50

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

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)
HARDNESS (BHN)
350-400 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"	100-140
4.0mm x 350mm	5/32" x 14"	140-180

### RE-DRY CONDITIONS

- Re-dry the electrode at 250°C for 1 hour.

NOTE:  
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