

Ratna HF LH

CLASSIFICATION

- DIN-8555 E2 -UM-60-S

APPLICATIONS

- Suitable to work on high carbon and high sulphur steels without cracks.
- Crane wheels, drill bits, crusher hammers, shear blades, rock drill cane cutting knives.
- Impellers, oil expeller worms, conveyor buckets, sprockets etc.
- Unique in its versatility of applications in areas of building-up worn-out parts and hard facing.

DESCRIPTION

- A medium heavy coated hydrogen controlled, iron powder, air hardening type hard facing electrode with weld deposits are hard and cannot be machined. Weld dressing is possible by grinding, can withstand friction and moderate impact.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)					
CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	CHROMIUM (CR)	MOLYBDENUM (MO)	VANADIUM (V)
0.50-0.80	1.00 MAX	0.75 MAX	6.00-8.00	0.40-0.60	0.20-0.40

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

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)
HARDNESS (BHN)
550-650 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"	100-130
4.0mm x 350mm	5/32" x 14"	150-180

RE-DRY CONDITIONS

- Re-dry the electrode at 250°C-300°C for 1 hour.

NOTE:
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