

Ratna R-CCR 100SPL

APPLICATIONS

- Blast furnace bells & hooper's
- Refractory press screws.
- Conveyor screws, cement press crews.
- Dredger bucket screws, bucket teeth & lips.
- Tube mill and rolling mill guides, pug mill knife.

DESCRIPTION

- Basic coated, hard facing electrode for achieving high deposition efficiency 170% approx. High resistant to abrasion due to high content of chromium and carbon. Machining by grinding. Resistant to heavy mineral abrasion and moderate.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)

CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	CHROMIUM (CR)	NICKEL (NI)
5.00 MAX	1.00 MAX	2.00 MAX	24.0-28.0	3.50-4.50

CURRENT POLARITY

DC(+), AC

WELDING POSITION

FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)

HARDNESS HRC

56-62 HRC

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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