

Ratna R-CCR 80

APPLICATIONS

- Surfacing of worn-out part subject to high temperature abrasion.
- Erosion, metal to metal wear and Impact.
- Foundry parts, agricultural and earth moving equipment.
- Construction, power plant, brick and cement industries.
- Plough shares, dragline bucket lips, mixer blades, conveyor and screws.
- Coal crushing hammers, air rings, cane knives.

DESCRIPTION

- Unique electrodes deposit weld metal resistance to heavy abrasion and metal to metal wear of mild and low alloys steels. The weld is dense, sound and non-machinable type. Electrodes easy operating characteristics on AC as well as on DC(+) welding current.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)

CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	CHROMIUM (CR)
3.00-4.00	1.50 MAX	1.00 MAX	28.0-32.0

CURRENT POLARITY

DC(+), AC

WELDING POSITION

FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)

HARDNESS HRC

52-62 HRC

SIZE AND CURRENT RECOMMENDATIONS

SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
2.5mm x 350mm	3/32" x 14"	100-130
3.2mm x 350mm	1/8" x 14"	150-180
4.0mm x 350mm	5/32" x 14"	210-260

RE-DRY CONDITIONS

- Re-dry the electrode at -350°C for 1 hour.

NOTE:

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