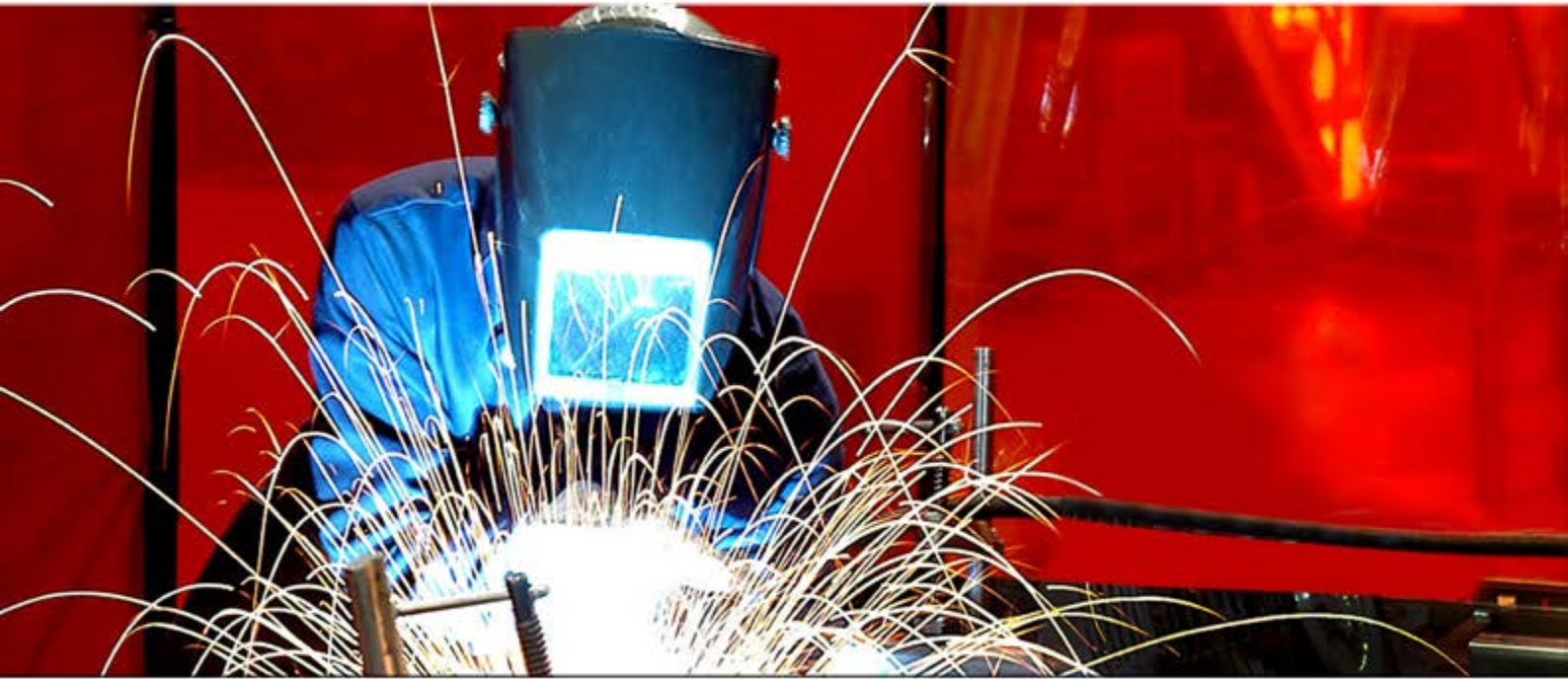


AN ISO 9001 : 2008 CERTIFIED COMPANY
A TRUSTED NAME IN WELDING



RASI®

**GENERAL CATALOGUE
WELDING CONSUMABLES**



RASI ELECTRODES LTD is an ISO 9001:2008 certified company located at Chennai, India. The Company is a public limited company established in 1994. The Company is a specialist in manufacturing quality **WELDING ELECTRODES and WELDING WIRES** catering to the requirements of diverse Heavy and Light Engineering industries. The Company is one of the preferred suppliers of **WELDING CONSUMABLES** under the brand name "RASI" for reputed public sector undertakings and larger private sector engineering conglomerates and other Original Equipment Manufacturers. The Company also deals in diverse welding products such as welding machines and accessories.

MANUFACTURING PRODUCTS

The Company manufactures the following range of products at its ISO Certified Manufacturing Plants adhering to stringent quality standards with near zero percent quality deviation standards:

- SMAW (STICK) WELDING ELECTRODES
- MIG / TIG FILLER WIRES
- MIG / MAG (Co2) WELDING WIRES
- SUB MERGED ARC WELDING WIRES

TRADED PRODUCTS

The Company also imports and markets a range of WELDING PRODUCTS from reputed manufacturers from around the world. The following is the broad range of product portfolio of traded / marketed products:

- FLUX CORED WIRE'S
- S.A.W. FLUXES (Fused & Agglomerated)
- WELDING EQUIPMENTS - (ARC Welding Transformers, Rectifiers, MIG / MAG Machines / TIG Machines, etc.,)
- GRINDING WHEELS AND CUT OFF WHEELS.
- NATURAL RUTILE ORE.,
- QUALITY POWER TOOLS.
- TUNGSTEN RODS, etc.,

The mentioned products marketed under the brand name of **RASI®** also carries the same quality assurance standards as the products directly manufactured by the Company. The Welding Machineries and Equipments being marketed are supported by reliable after sales service by the Company.

The Company's motto is '**Quality, Economy and Dependability**'. The Company accords highest priority for delighting its customers to the maximum and all its manufacturing and marketing efforts are focused towards meeting this end. The Company has highly qualified technical staff who not only market the Company's products but also critically study the customers needs and applications and make suitable recommendation for optimizing their objectives of achieving **BEST WELDING PERFORMANCE, PRODUCTIVITY AND RELIABILITY AND COST REDUCTION** in each areas of their welding operations. The Company also trains the Customers personnel on an end to end basis for achieving optimum welding performance.

PRESTIGIOUS APPROVALS AND ACCREDITATIONS

The Companies Quality Management System is Certified by DNV -Netherlands, and has secured approvals and accreditations from the following reputed institutions:



SMAW (STICK) WELDING ELECTRODES



Shielded metal arc welding (SMAW), also known as manual metal arc (MMA) welding, flux-shielded arc welding or informally as stick welding, is a manual arc welding process that uses a consumable electrode coated in flux to lay the weld. An electric current, in the form of either alternating current or direct current from a welding power supply is used to form an electric arc between the electrode and the metals to be joined. As the weld is laid, the flux coating of the electrode disintegrates, giving off vapors that serve as a shielding gas and providing a layer of slag, both of which protect the weld area from atmospheric contamination.

Because of the versatility of the process and the simplicity of its equipment and operation, shielded metal arc welding is one of the world's most popular welding processes. It dominates other welding processes in the maintenance and repair industry, and though flux-cored arc welding is growing in popularity, SMAW continues to be used extensively in the construction of steel structures and in industrial fabrication. The process is used primarily to weld iron and steels (including stainless steel) but aluminium, nickel and copper alloys can also be welded with this method.

RASI ELECTRODES LIMITED has a wide range of welding electrodes, catering to the vast fabrication industries. Specially formulated welder friendly welding electrodes for excellent welds with easy slag peel for less downtime on chipping and cleaning and increasing your productivity with considering the economical factor.

RASI RANGE OF WELDING ELECTRODES FOR:

GENERAL PURPOSE MILD STEEL ELECTRODES

RASI - E 6013 | E 6013 R | E 6013 RR | E 7018 | Gold-weld E 6013 | Ba-jaj E 6013

LOW HYDROGEN / MILD STEEL SPECIAL ELECTRODES

RASI - E 7018 | E 7018 -1 | E 7018 -1 H4R | E 7024 | E 8016 - G

LOW HYDROGEN LOW ALLOY - HIGH TENSILE ELECTRODE

RASI - E 7016 | E 7018 -1 | E 7018 - A1 | E 7018 - G | E 8018 - G | E 8018 - B2 | E 8018 - B3 | E 8018 - B6 | E 8018 - B8 | E 8018 - W2 | E 8018 - C1 | E 8018 - C2 | E 8018 - C3 | E 9018 - G | E 9018 - D1 | E 9018 - B3 | E 9018 - B9 | E 9018 - M | E 10018 - M | E 8016 | E 8016 - B2 | E 9016 - G | E 9016 - B3 | E 9016 - B9 | E 8013 - G | E 11018-M | E 11016-G

STAINLESS STEEL & HEAT RESISTING STEEL

RASI - Silver-Arc - E 308L - 16 | E 308L - 15 | E 309L - 16 | E 309 - 16 | E 309LMo - 16 | E 347 - 16 | E 316 L - 16 | E 312 - 16 | E 310 - 16 | E 310 - 15 | E 410 - 16 | E 430 - 16

HARD FACING WELDING ELECTRODE

RASI - HF - 250 R | HF 350 R | HF 450 R | HF 550 R | HF 650 R | HF 600 LH | HF MANG-13 | HF MANG-ALLOY | HF VPN 800 | HF TUNCARB | HF Cr 33

CAST IRON ELECTRODE

RASI - Ci -NM | Ci - Fe Ni | Ci - Monel | Ci - Ni | E Ni Cu-B

PIPE WELDING ELECTRODES

RASI E 6010 | E 6011 | E 7010 - G | E 7010 - P1 | E 8010 - G

CATERING TO INDUSTRIES SUCH AS :*

IRON & STEEL INDUSTRIES | CEMENT INDUSTRIES | THERMAL POWER STATIONS FABRICATION INDUSTRIES | MANUFACTURING INDUSTRIES | COAL & OTHER MINES | AUTOMOBILE INDUSTRIES | BOILERS | SUGAR INDUSTRIES | MAINTENANCE | CONSTRUCTION | CHEMICAL & FERTILIZERS INDUSTRIES | FOOD & BEVERAGE INDUSTRIES | ENGINEERING & TECHNICAL | AEROSPACE | DEFENSE | EQUIPMENT MANUFACTURING | OIL & GAS INDUSTRIES | PHARMACEUTICAL INDUSTRIES | TURNKEY PROJECTS | MINING INDUSTRIES | AUTOMOTIVE COMPONENTS | GENERAL FABRICATIONS

*Ask for welding handbook for other grades

LOW HEAT INPUT WELDING ELECTRODES

MAINTENANCE / REPAIR / RECLAMATION



Effective maintenance and repair are essential for efficient running of industries. welding, as a tool of maintenance and repair, plays a vitally important role in the functioning of all major industries. In general it may be said that practically any metal part which has broken or worn-out in service can be reclaimed by welding. In fact, one of the first uses of welding was to repair broken machinery and parts. what started out, as a process for making an emergency repair until a replacement could be obtained, has today become an economic necessity to conserve expensive materials and to reduce inventories.

RASI - ULTRA TECH A wide range of welding electrodes specially designed for low heat input welding. These electrodes are the result of extensive development, testing and analysis in our well-equipped modern laboratories. The advantages of welding, particularly for maintenance and repair applications, with low heat input ULTRATECH electrodes needs no emphasis. It is well known that the composition and metallurgical state of the base material affects the properties of the deposited weld metal since the first layer will always be diluted with base material. There is also risk of damage to the desirable structure in the heat-affected zone of the base material. It is in this context that the introduction of ULTRATECH low heat input electrodes can be fully appreciated.

YOU DERIVE THE FOLLOWING BENEFITS WHEN YOU USE ULTRATECH ELECTRODES:

- Reduced pick-up of carbon and other detrimental elements from the base material.
- Minimal effect on the surface of the base material adjacent to the fusion zone, known as heat-affected zone.
- Reduced propensity for grain coarsening in weld metal and heat affected zone, thereby resulting in better toughness of weld and heat affected zone.
- Reduced width of the heat-affected zone.
- Reduction in the cracking tendency of the highly brittle materials due to reduced 'thermal shock';
- Less distortion of the weldment.
- Lower consumption of electrodes, especially in hardfacing applications due to lower dilution with the parent material.

Through developments in the design of flux coating, it has been ensured that each ULTRATECH electrode performs at low welding currents, low arc voltage and short arc length. These factors are strictly controlled to ensure that you get the maximum advantage of low heat input welding with ULTRATECH electrode.

RANGE OF ULTRATECH WELDING ELECTRODES -

WELDING ALLOYS OF STEELS.

ULTRATECH - 13 | ULTRATECH - 14 | ULTRATECH - 15

WELDING ALLOYS FOR DISSIMILAR STEELS

ULTRATECH - 16 | ULTRATECH - 16S | ULTRATECH - 18 | ULTRATECH - 18T | ULTRATECH - 19 | ULTRATECH - 19H

WELDING ALLOYS FOR CAST IRON

ULTRATECH - 25 | ULTRATECH - 25F | ULTRATECH - 26 | ULTRATECH - 27 | ULTRATECH - 28

WELDING ALLOYS FOR STAINLESS STEEL

ULTRATECH - 33 | ULTRATECH - 33L | ULTRATECH - 33M | ULTRATECH - 34 | ULTRATECH - 35

WELDING ALLOYS FOR COPPER & NON FERROUS ALLOYS

ULTRATECH - 40 | ULTRATECH - 41

WELDING ALLOYS FOR NICKEL & NICKEL ALLOYS (INCONEL & HAST ALLOYS)

ULTRATECH - 52 | ULTRATECH - 53

WELDING ALLOYS FOR HARDSURFACING & WEAR RESISTANCE

ULTRATECH - 61LH | ULTRATECH - 62 | ULTRATECH - 63 Cr-Mn | ULTRATECH - 63 Ni-Mn |
ULTRATECH - 64 | ULTRATECH - 65 | ULTRATECH - 66 | ULTRATECH - 68 | ULTRATECH - 69

ELECTRODES FOR CUTTING AND GOUGING

ULTRATECH - 70 | ULTRATECH - 71

*Please ask for Welding hand book for low heat input welding for details of each product.

COPPER COATED MILD STEEL (MIG/MAG) WIRE



Gas metal arc welding (GMAW), sometimes referred to by its subtypes metal inert gas (MIG) welding or metal active gas (MAG) welding, is a semi-automatic or automatic arc welding process in which a continuous and consumable wire electrode and a shielding gas are fed through a welding gun. A constant voltage, direct current power source is most commonly used with GMAW, but constant current systems, as well as alternating current, can be used. There are four primary methods of metal transfer in GMAW, called globular, short-circuiting, spray, and pulsed-spray, each of which has distinct properties and corresponding advantages and limitations.

RASI®- CO2

COPPER COATED MILD STEEL WIRE/ MIG WELDING WIRE

CLASSIFICATIONS

IS. : 6419-71 Grade S-4
AWS - A 5.18 ER 70S-6

CHARACTERISTICS

RASI CO2 is a double deoxidized copper coated Mn-Si wire for GMAW using CO2 or 80% Ar, 20% CO2 mixtures for shielding of Weld Metal. The Weld Metal is of Radiography Quality.

APPLICATIONS

RASI CO2 is all position welding wire and is used for:

- * Welding of all sheet metal and structural steels
- * Carbon & Low Alloy Steels
- * Pressure Vessels etc.

CHEMICAL COMPOSITION OF WIRE

ELEMENT	C	Mn	Si	S	P	Cu
% (MAX)	0.06-0.15	1.40-1.85	0.80-1.15	0.035	0.025	0.5

MECHANICAL PROPERTIES OF ALL-WELD METAL WITH CO2 GAS SHEILDING

UTS (N/mm ²)	Ys (N/mm ²)	Elongation %	CVN - Impact
>480	>400	>22	At 20° / -30° c 100/40J

NOTE : Single values shown above are maximum

CURRENT CONDITIONS: DC [+] ONLY

SIZE	0.8mm	1.0mm	1.2mm	1.6mm
Current (Amps)	50-180	80-200	120-260	150-350

PACKING	SIZE (in mm)	WEIGHT
Spools (layer winding)	0.80 1.00 1.20 1.60	12.50/15 kg Net
Spools (Random winding)	0.80 1.00 1.20	12.5 kg Net

PRECAUTIONS: Use short arc during welding. Store the wire in dry conditions. Avoid moisture.

FLUX - CORED ARC WELDING



Flux-cored arc welding (FCAW or FCA) is a semi-automatic or automatic arc welding process. FCAW requires a continuously-fed consumable tubular electrode containing a flux and a constant-voltage or, less commonly, a constant-current welding power supply. An externally supplied shielding gas is sometimes used, but often the flux itself is relied upon to generate the necessary protection from the atmosphere. The process is widely used in construction because of its high welding speed and portability.

RASI® E 71 - T 1 (SFA 5.20 AWS: E 71 T-1)

RASI E 71 T-1 Mild steel flux cored wire with rutile slag base, all position welding, stable arc and good slag detectability with Multi-pass welding.

CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	S&P
PERCENTAGE	0.18	1.75	0.9	0.03

ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm ²)	>480	Elongation %	>22
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RASI® E 71 - T 5 (SFA 5.20 AWS: E 71 T-5)

RASI E 71 - T5 Low hydrogen flux cored wire with Basic slag base, all position welding, stable arc and good slag detachability

CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	S&P
PERCENTAGE	0.18	1.75	0.9	0.03

ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm ²)	>480	Elongation %	>22
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RASI® E 90T5-G (SFA 5.29 AWS: E 90T5-G)

RASI E 90T5-G Low hydrogen low alloy high-tensile lime fluoride base slag with uniform weld bead. The weld metal is radiographically sound.

CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	Mo	S&P
E%	0.15	2.25	0.8	0.55	0.03

ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm ²)	>620	Elongation %	>17
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RASI® E 308L-TI (SFA 5.22 AWS: E 308L-T1-1)

RASI E 308L-T1 Stainless Steel Flux Cored wire with rutile slag base, for all position welding, stability arc and good slag detachability.

CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	Cr	Ni
PERCENTAGE	0.04	0.5-2.5	1.0 Max	18-21	09-11

ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm ²)	>520	Elongation %	>35
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RASI® E 309L-TI (SFA 5.22 AWS: E 309L-T1-1)

RASI E 309L-T1 Stainless Steel Flux Cored wire with rutile slag base, for all position welding, stable arc and good slag detachability.

CHEMICAL COMPOSITIONS OF ALL WELD METAL

ELEMENT	C	Mn	Si	Cr	Ni
PERCENTAGE	0.04	0.5-2.5	1.0 Max	22-25	12- 14

ALL WELD METAL MECHANICAL PROPERTIES

UTS (N/mm ²)	>520	Elongation %	>35
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NOTE: ALL SINGLE VALUES ABOVE ARE MAXIMUM

PACKING	LAYER WINDING 15 Kgs (Net)
PRECAUTION	Use short ARC during welding, Store the wire in Dry Condition

TUNGSTEN INERT GAS (TIG) WELDING



Gas tungsten arc welding (GTAW), also known as tungsten inert gas (TIG) welding is an arc welding process that uses a non-consumable tungsten electrode to produce the weld. The weld area is protected from atmospheric contamination by a shielding gas (usually an inert gas such as argon), and a filler metal is normally used, though some welds, known as autogenous welds, do not require it. A constant-current welding power supply produces energy which is conducted across the arc through a column of highly ionized gas and metal vapors known as a plasma.

GTAW is most commonly used to weld thin sections of stainless steel and non-ferrous metals such as aluminum, magnesium, and copper alloys. The process grants the operator greater control over the weld than competing processes such as shielded metal arc welding and gas metal arc welding, allowing for stronger, higher quality welds. However, GTAW is comparatively more complex and difficult to master, and furthermore, it is significantly slower than most other welding techniques. A related process, plasma arc welding, uses a slightly different welding torch to create a more focused welding arc and as a result is often automated.

RASI® TIG FILLER WIRES

STAINLESS STEEL FILLER WIRE FOR TIG WELDING

CLASSIFICATION AND CODING

BRAND	RASI TIG 304 L	RASI TIG 308 L	RASI TIG 309 L	RASI TIG 310	RASI TIG 312	RASI TIG 316 L	RASI TIG 347	RASI TIG 410
CODE AWS:A5.9	ER 304 L	ER 308 L	ER 309 L	ER 310	ER 312	ER 316 L	ER 347	ER 410

APPLICATIONS

RASI TIG 304 L : ASTM/AISI 304,304 L Joining To Similar Composition

RASI TIG 308 L : ASTM/AISI 304,304 L, 308, 308 L Joining To Similar Composition

RASI TIG 309 L : ASTM/AISI 309,309S and Dissimilar Composition Ss - Ms Welding. Overlays ON M.S., Low Alloy Steels/Cladding

RASI TIG 310 : Joining of Heat Resistance Dissimilar Stainless Steels

RASI TIG 312 : Joining to Dissimilar and Difficult to Weld Steels with known and Unknown Chemical Composition

RASI TIG 316 L : Joining TO 316, 316 L and for Surface Applications

RASI TIG 347 : Joining / Filling of AISI 347 and 321 material

RASI TIG 410 : Joining / Filling of 13% Chrome Steel and Equitant

SHIELDING GAS : ARGON FLOW RATE : 4 - 8 L / Min

CHEMICAL COMPOSITION OF FILLER WIRE

BRAND	C	Mn	Si	S & P	Cr	Ni	Mo
RASI TIG 308 L	0.04	1.0 - 2.5	0.3 - 0.65	0.03	19 - 22	09.0 - 11.0	0.75
RASI TIG 309 L	0.04	1.0 - 2.5	0.3 - 0.65	0.03	23 - 25	12.0 - 14.0	0.75
RASI TIG 310	0.15	1.0 - 2.5	0.3 - 0.65	0.03	25 - 28	20 - 23	0.75
RASI TIG 312	0.15	1.0 - 2.5	0.3 - 0.65	0.03	28 - 32	8.0 - 11.0	0.75
RASI TIG 316 L	0.04	1.0 - 2.5	0.3 - 0.65	0.03	18 - 20	11 - 14	2.0 - 3.0
RASI TIG 347	0.08	1.2 - 5.0	0.3 - 0.65	0.03	19 - 21	9 - 11	0.75
RASI TIG 410	0.12	0.6	0.5	0.03	11.5 - 13.5	0.6	0.75

PACKING (1000mm Cut Length)

STANDARD WIRE SIZES (Dia in MM) : 0.80 1.00 1.20 1.60 2.00 2.50 3.15

WE OFFER THE ABOVE WIRE IN SPOOL FORM ALSO FOR SIZE (Dia in MM) 0.80 1.00 1.20 and 1.60

Packing : Air Tight HDPE Packet With Polythene Sinking (Embossed with grade on each wire)
5 kg packing in plastic box and 12.50/15 kg in spool form.

SUBMERGED ARC WELDING

WIRE & FLUX



Submerged arc welding (SAW) is a common arc welding process. It requires a continuously fed consumable solid or tubular (flux cored) electrode. The molten weld and the arc zone are protected from atmospheric contamination by being "submerged" under a blanket of granular fusible flux consisting of lime, silica, manganese oxide, calcium fluoride, and other compounds. When molten, the flux becomes conductive, and provides a current path between the electrode and the work. This thick layer of flux completely covers the molten metal thus preventing spatter and sparks as well as suppressing the intense ultraviolet radiation and fumes that are a part of the shielded metal arc welding (SMAW) process.

S.A.W. WIRE

RASI® EL - 8 WIRE

COPPER COATED CONTINUOUS SOLID WIRE FOR SUBMERGED ARC WELDING

CLASSIFICATIONS

ASME SEC-II, PART 'C'

SFA 5.17 GRADE: EL - 8

CHARACTERISTICS

Is a Low Manganese copper coated Mild Steel wire for submerged Arc Welding.

CHEMICAL COMPOSITION OF WIRE

C	Mn	Si	S & P
0.1	0.33 - 0.60	0.03	0.03

MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (N/mm ²)	Ys (N/mm ²)	Elongation %
410 - 510	330 Min	22% Min

Note: Single Values are maximum %

PACKING SPECIFICATION : IN COIL FORM

EACH SPOOL IS WRAPPED WITH POLYTHENE

PRECAUTIONS: Choose the suitable flux for welding. Use short arc

INNER DIAMETER	300 mm
WIDTH	100 mm
WEIGHT	25 Kgs Net.

CHEMICAL COMPOSITION OF FLUX

BRAND	CODING	CHARACTERISTICS
RASI - EL - 8	SFA 5.17 AWS: F7AZ EL-8	Agglomerated and fused flux, all purpose Si - Mn flux for SAW welding
RASI - EM 12 K	F7A6-EM12K / F7P6-EM12K	Agglomerated fully basic flux designed for multi pass welds
RASI - SJ - 101	F4A2-H08MnA / F5A4-H10Mn2	SJ101 is a kind of fluoride-alkalinity and slag-series sintered flux
RASI - SJ - 102	AWS-A5.17 F7A4-EH14:F6A4-EM12K	High basicity sintered flux, basicity 3.0, have a good welding procedure
RASI - WD 8010	F410-H1Cr1 3/F 308-H0Cr21 Ni10	WD - 8010 is an agglomerated Aluminate-basic type flux

Packing: All Flux are packed in 25 Kgs HDPE bags

GRINDING & CUTTING WHEELS & POWER TOOLS



GRINDING WHEELS

BRAND	SIZE	QTY/BOX	WEIGHT/BOX
RASI	100 X 4 X 16 mm	200 Pcs	14 Kg.
RASI	100 X 6 X 16 mm	200 Pcs	21 Kg.
RASI - REGULAR	180 X 7 X 22.2 mm	50 Pcs	21 Kg.
RASI - SPECIAL	180 X 7 X 22.2 mm	50 Pcs	21 Kg.
RASI	125 X 6 X 22 mm	100 Pcs	17 Kg.

CUTTING WHEELS

BRAND	SIZE	QTY/BOX	WEIGHT/BOX
RASI	105 X 1 X 16 mm	500 Pcs	13 Kg.
RASI	105 X 2.5 X 16 mm	400 Pcs	21 Kg.
RASI	180 X 3 X 22 mm	100 Pcs	18 Kg.
RASI - REGULAR	350 X 3 X 25.4 mm	25 Pcs	16 Kg.
RASI - SPECIAL	350 X 3 X 25.4 mm	25 Pcs	16 Kg.

POWER TOOLS



RASI® - CUT 355

- ▶ 14" Basic cut-off Model for high speed cutting
- ▶ Low maintenance and High Performance
- ▶ Light weight chop saw to Cut upto 100mm

PRODUCT SPECIFICATIONS

Blade Diameter	Max. Cutting Capacity	No - Load Speed	Rated Input Power	Rated Voltage	Rated Frequency
355 mm	100 mm	3800r/min.	2200 W	220/110V~	50/60Hz



RASI® - CUT 871

- ▶ Soft Overload Protection
- ▶ Cast Aluminium Framework
- ▶ Cutting wheel is placed accurately
- ▶ High Precision Cutting, 2300W super power
- ▶ Double Insulation for higher protection

PRODUCT SPECIFICATIONS

Blade Diameter	Max. Cutting Capacity	No - Load Speed	Rated Input Power	Rated Voltage	Rated Frequency
355 mm	100 mm	3800r/min.	2300 W	220/110V~	50/60Hz



RASI® - AG - 1252

- ▶ The process of stator improved for fast heat dissipation
- ▶ A Unique machine with high durability and excellent performance
- ▶ Easy grinding and cutting with rated input power of 1200W
- ▶ Double Insulation with Self-locking

PRODUCT SPECIFICATIONS

Max. Diameter	Spindle Thread	Rate Speed	Rated Input Power	Rated Voltage	Rated Frequency
125 mm	M14	9200r/min.	1200 W	220/110V~	50/60Hz



RASI® - AG - 801

- ▶ The process of stator improved for fast heat dissipation
- ▶ Universal fitting parts for easy maintenance
- ▶ Double Insulation with Self-locking
- ▶ Armature with NSK bearing, head housing apply dust & durable
- ▶ Rated input power reached 800 Watts, suitable for professional users

PRODUCT SPECIFICATIONS

Max. Diameter	Spindle Thread	Rated Speed	Rated Input Power	Rated Voltage	Rated Frequency
100/115 mm	M10	11000r/min.	800 W	220/110V~	50/60Hz



RASI® - AG - 1802

- ▶ A Unique machine with high durability and excellent performance
- ▶ Easy grinding and cutting with rated input power of 2000W
- ▶ Double Insulation with Self-locking

PRODUCT SPECIFICATIONS

Max. Diameter	Spindle Thread	Rated Speed	Rated Input Power	Rated Voltage	Rated Frequency
180/230 mm	M14	8500r/6500r/min.	2000 W	220/110V~	50/60Hz

WELDING MACHINES

ARC / MIG / TIG / CUT SERIES

INVERTER DC MANUAL METAL ARC WELDING MACHINE



TECHNICAL DATA

MODEL	RATED INPUT POWER	RATED INPUT CAPACITY (KVA)	RATED DUTY CYCLE (%)	OUTPUT CURRENT (A)	RATED DUTY VOLTAGE (V)	EFFICIENCY (%)	POWER FACTOR	WEIGHT (KG)	DIMENSION LxWxH (MM)
HM 315	3 - phase	13	60	30 - 315	32.6	85	0.93	40	600x320x625
HM 400	380V +/- 10%	18	60	40 - 400	36	85	0.93	42	600x320x625
HM 500	50 Hz	26	60	50 - 500	40	85	0.93	47	600x320x625
HM 630		36	60	50 - 630	44	85	0.93	60	600x320x625

INVERTER DC PULSED GAS TUNGSTEN ARC WELDING MACHINE



TECHNICAL DATA

MODEL	RATED INPUT POWER	POST FLOW TIME (S)	PULSE RATE (%)	UP/ DOWN SLOP TIME (S)	RATED INPUT CAP. (KVA)	RATED DUTY CYCLE (%)	RATED OUTPUT CURRENT (A)	PULSE FREQ. (HZ)	EFFICIENCY (%)	POWER FACTOR	WEIGHT (KG)	DIMENSION LxWxH (MM)
TIG - 200 P	1 - Phase 220V +/- 10% 50/60Hz	(1 - 10)	(10 - 90)	(1 - 5)	4.4	35	10 - 200	0.5 - 200	85	0.93	18	435x195x380
TIG - 315 P	3-Phase	(1 - 10)	(10 - 90)	(1 - 5)	8.8	60	20 - 315	0.5 - 200	85	0.93	40	585x315x455
TIG - 400 P	380 +/- 10% , 50 Hz	(1 - 10)	(10 - 90)	(1 - 5)	12	60	40 - 400	0.5 - 200	85	0.93	50	593x358x605

GAS METAL ARC WELDING / MIG /MAG WELDING MACHINE



TECHNICAL DATA

MODEL	RATED INPUT POWER	RATED INPUT CAPACITY (KVA)	RATED DUTY CYCLE (%)	RATED OUTPUT CURRENT (A)	SUITABLE WIRE DIAMETER (MM)	EFFICIENCY (%)	POWER FACTOR	WEIGHT (KG)	DIMENSION LxWxH (MM)
MIG 200		7.6	60	50 - 200	0.80, 1.00	60	0.82	100	675x376x747
MIG 250	3 - phase	9.4	60	50 - 250	0.80, 1.00	85	0.9	29	530x280x510
MIG 350	380V +/- 10%	18	60	60 - 350	1.0, 1.20	60	0.82	125	675x376x747
MIG 500	50 Hz	32	60	100 - 500	1.20, 1.60	60	0.82	175	710x436x817

PORTABLE DIGITAL - CONTROL PLASMA CUTTING MACHINE



TECHNICAL DATA

MODEL	RATED OUTPUT CURRENT (A)	DUTY CYCLE (%)	PIERCE THICKNESS (MM)	CUTTING SPEED	CUTTING ANGLE	POWER CAPACITY (KW)	WEIGHT (KG)	DIMENSION LxWxH (MM)
Powermax 1000	20 - 60	50	10 (max : 12)	1041 mm/m(10mm)	5	6	37	586x271x498
Powermax 1250	20 - 80	50	10 (max : 12)	991 mm/m (12mm)	5	12	44	586x271x498
Powermax 1650	20 - 100	80	13 (max : 19)	1447 mm/m(12mm)	5	16	58	671x427x655
Cutmaster - 51	20 - 40	50	6 (max : 15)	1140 mm/m(6mm)	5	6	32.7	416x273x572
Cutmaster - 81	20 - 60	50	10 (max : 25)	1120 mm/m(10mm)	5	6	47.6	439x315x696
Cutmaster - 101	20 - 60	50	12 (max : 30)	970 mm/m (12mm)	5	6	47.6	457x315x696
Cutmaster - 151	20 - 100	50	15 (max : 35)	700 mm/m (15mm)	5	12	47.6	439x315x696



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