



LARSEN & TOUBRO LIMITED

Powai Works, Saki Vihar Road, P. O. Box 8901, Mumbai-400 072 • Tel. : 2858 1401/11

E-Mail :

Ref. :

Date : 28th April 2003

To
M/s Raj Kesari Electrodes Private Limited,
F-313 , Road No. 12,
Mewar Industrial Area,
Madri , Udaipur 313 001
RAJASTHAN

Kind Attn. : Mr. Rakesh Bairaria
(Dy. General Manager Marketing)

Dear Sir ,

Sub. : Approval of your welding electrodes

This is with reference to your following electrode brands which were identified for testing during the audit of your works at Udaipur.

<u>Sl.No.</u>	<u>Brand</u>	<u>AWS Class</u>
1.	RAJCORD-13S	E 6013
2.	SUPERLET- 18	E 7018

Test pieces were prepared using electrodes drawn from packets sealed at that time . All the tests as required by ASME Section II Part C have been conducted and the results of the tests were satisfactory.

Particular mention must be made of the result of the Diffusible Hydrogen Test and Impact tests as saliently good results observed.

The Diffusible Hydrogen was found to be < 5 ml/100gm in the SUPERLET- 18 electrode.

The CVN impact test conducted on SUPERLET- 18 at -29°C and on RAJCORD-13S at 0°C yielded toughness values of 91 Joules and 79.33 Joules respectively.

Based on the test results the above brands are approved.

S.H.Dhamdhare
Asst.Gen.Manager
Welding Engg. Sec. & QA&I Chem P&S SBU
E&C Division .