

ROYAL 7018 C3L (AWS:SFA 5.5, E 7018 C3L)

AWS : SFA 5.5, E 7018 C3L EN ISO 2560 A E 42 5 1Ni B 32 H5

Applications

It is used for welding of nickel alloy piping, system valves and tanks. Used for welding low temperature service for Locomotive main frames, Refineries, Pipelines, Equipments, fabrication of pressure vessels.

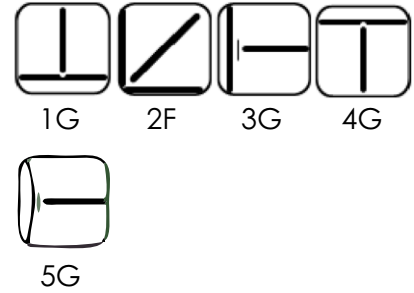
Characteristics on Usage

A medium heavy coated low hydrogen iron powder type electrodes. the weld metal deposits 1.0 % Ni in the weld metal. It is specially designed for welding fine grained steel, nickel alloy steel. It gives high ductility , toughness and resistance to the service temperature at minus 50 °C

Notes On Usage

- ☞ Dry the electrode at 250 - 300 °C for 60 Min- before use .
- ☞ Keep the arc as short as possible.

Welding Positions



LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.08 Max	0.40 - 1.40	0.50 Max	0.030 Max	0.030 Max	0.15 Max	0.80 - 1.10	0.35 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 50 o C (J)
490 Min	390 Min	22 Min	27 Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC/DC (+)	60-90
3.15 x 450	5	20		100-140
4.00 x 450	5	20		140-180
5.00 x 450	5	20		180-250