

ROYAL 8018C3

AWS : SFA 5.5, E 8018-C 3 EN ISO 2560 A E 46 4 1 Ni B 32 H5

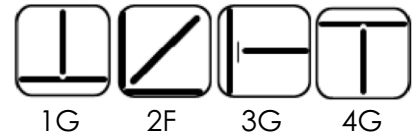
Applications

It is used for welding of nickel alloy equipments. Fabrication of pressure vessels, piping system, valves and tanks. Used for welding low temperature service for Locomotive main frames, Refineries, Pipe lines.

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 steel and nickel alloy steel . It gives high ductility, toughness and resistance to the service temperature at minus 40 C. The electrode gives smooth arc with medium penetration and negligible spatter. It is all position electrodes with Radiographic quality of weld deposit.

Welding Positions



Notes On Usage

- ⌚ Dry the electrode at 250 - 300°C for 1 hour before using.
- ⌚ Keep the arc as short as possible.

LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.12 Max	0.40 - 1.25	0.80 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 -40 °C (J)
550 Min	470 Min	24 % Min	27 Joules 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