

ROYAL 9018 M (E 9018M)

AWS : SFA 5.5, E 9018M IS : 1395E 63 BG129Fe EN ISO 18275 A E 55 4 1.5NiMo B 32 H5

Applications

Welding of grain refined steels. Q&T steel, HSLA steel, and ASTM A615 Grade 60 steel, structural fabrication, Penstocks, Tanks, pressure vessels.

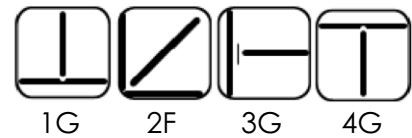
Characteristics on Usage

A heavy coated low hydrogen iron powder type electrodes , welding in all positions used for welding steel having high tensile strength upto 70 Kg/mm² as well as low alloy structural steel. The weld is of radiographic like quality having excellent welding characteristics like crack

Notes On Usage

- ☞ Dry the electrodes at 250 - 300°C for 60 min before use.
- ☞ Keep the arc as short as possible .
- ☞ Adopt back step method or strike the arc on a small plate prepared for this particular purpose because ar striking o the base metal is in danger of initing cracking.

Welding Positions



LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	0.60-1.25	0.80 Max	0.030 Max	0.030 Max	0.15 Max	1.40-1.80	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° C (J)	HARDNESS
620 Min	540 Min	24 % Min	27 Joules Min	200 BHN Max

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	70-100
3.15 x 450	5	20		100-140
4.00 x 450	5	20		140-180
5.00 x 450	5	20		180 - 230