

ROYAL MOLY THERM – SPL (E 8018 D3)

AWS : SFA 5.5, E 8018 D3 EN ISO EN ISO 18275 A E 46 4 Z B 32 H5

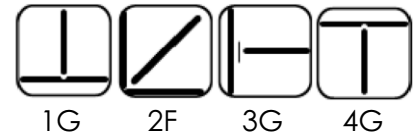
Applications

For welding 0.9% N & 0.5 Mo steel Suitable for welding of manganese molly steel. Low alloy high tensile boiler tubes & boiler Plates etc.

Characteristics on Usage

It is a medium heavy coated Hydrogen Controlled iron powder type all position electrodes deposit low alloy steel weld metal having 0.90% Ni & 0.50% Mo. Gives smooth arc, little spatter & easily removable slag. Specially suitable for the welding of Manganese molly steel and similar composition. The weld is of radiographic quality. Redry electrodes at 250o C for one hour for better result.

Welding Positions



Notes On Usage

- ⚠ Dry the electrode a 250 - 300 °C for 60 Min- before use .
- ⚠ Preheat at 100 - 200 °C & post heat at 620±15 °C
- ⚠ Keep the arc as short as possible.

LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%	Mo%
0.12 Max	1.0-1.75	0.80	0.030 Max	0.030 Max	0.90 Max	0.25-0.45

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)
560 – 660	460 – 570	19 %	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 (+)	70-100
3.15 x 450	5	20		90 – 130
4.00 x 450	5	20		140 – 180
5.00 x 450	5	20		180 – 220