

# ROYAL THERM - 100M (E 10018M)

SFA 5.5 AWS E 10018M IS : E68BM229Fe EN ISO 18275 A E 69 5 2 NiMo B 32 H5

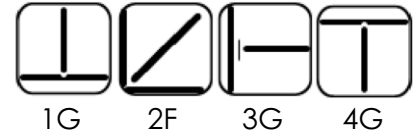
## Applications

Welding of high tensile steel such as USS – T - 1. Welding of Penstocks, Earth moving equipment's. Heavy duty structural steel, fabrication for High Tensile Steel.

## Characteristics on Usage

It is a medium heavy basic coated low hydrogen, low alloy iron powder type electrode, used for welding high tensile fully killed fine grained steel. The electrode has excellent welding characteristics and operates in all position. It gives radiographic quality of welds with easily removable slag and has good notch toughness down to minus 50 °C. It's deposition efficiency is approximately 112%, dry the electrode at 350 °C for 2 hours to obtain good results.

## Welding Positions



## Notes On Usage

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

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	0.75 – 1.70	0.60 Max	0.03 Max	0.03 Max	0.35 Max	1.40 – 2.10	0.25 – 0.50

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT ( CVN ) AT – 50 ° C ( J )
690 Min	600 Min	16 % 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 (+)	80 – 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