

ROYAL THERM - 110M (E 11018M)

SFA 5.5 AWS E 11018M IS : 814E 76BM329Fe EN ISO 18275 A E 69 5 Z B 32 H5

Applications

Welding of Penstocks, Earth moving equipments, Heavy duty structure made from high tensile steel. Petrochemicals Tanks & Vessels.

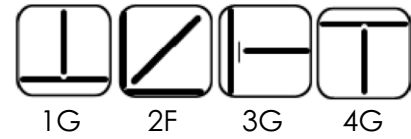
Characteristics on Usage

A basic coated low hydrogen iron powder type electrode used for welding high strength steel. the electrode is operating in all position and has excellent welding characteristics. the weld metal is of radiographic quality and possesses high strength combined with excellent toughness at sub Zero temperature. it is used for welding high tensile fine grained steel.

Characteristics on Usage

E.I.L.

Welding Positions



Notes On Usage

- ⌚ Dry the electrodes at 250 - 300°C for 60 minutes before use
- ⌚ Preheat at 150 - 200 °C
- ⌚ Keep the arc as short as possible.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	1.30 -1.80	0.60 Max	0.030 Max	0.030 Max	0.40 Max	1.25 - 250	0.25 - 0.50

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)
760 Min	680 Min	20 % 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 - 230
6.30 x 450				230 - 280