

# ROYAL THERM – 120G (E 12018G)

ROYAL THERM - 120G (E 12018G) EN ISO 18275 A E 69 5 Z B 32 H5

## Applications

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

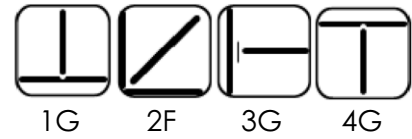
## Characteristics on Usage

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.

## Notes On Usage

- ☞ Dry the electrodes 250 - 300oC for 60 minutes before use
- ☞ Keep toe are as short as possible

## Welding Positions



LOW ALLOY HIGH TENSILE ELECTRODES

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	V%
0.10 Max	1.30 -2.25	0.60 Max	0.030 Max	0.030 Max	0.30-1.50	1.75 - 2.50	0.30 –0.55	0.050 Max

## 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 )
830 Min	745-830	18 % 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
6.30 x 450				230 – 280