

ROYAL THERM MOLY (E 7018 - A1)

AWS : SFA 5.5, E 7018 - A1 IS : E 49 B Al-2-6-Fe EN ISO 3580 A E Mn B 32 H5

Applications

Suitable for Boilers welding, Pressure Vessels Pipe and Tubes, High Temp. Application upto 525° C

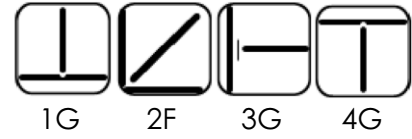
Characteristics on Usage

A low hydrogen, low alloy iron powder type basic coated all position electrode yielding a weld deposit containing 0.50%Mo. The weld metal is of radiographic quality and can withstand service temperature upto 525° C . smooth and weld rippled beads possessing excellent mechanical properties at room and at elevated temperature.

Approvals

L & T, IBR, N.P.C.I.L.

Welding Positions



Notes On Usage

- ☞ Dry the electrode at 250 - 300 °C for 60 Min- before use .
- ☞ Preheat at 100 - 200 °C & post heat at 620 -680 °C
- ☞ Keep the arc as short as possible.

LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni%
0.12 Max	1.25 Max	0.80 Max	0.030 Max	0.030 Max	3.0 - 3.75

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT R. Temp.(27 ± 2)
490 Min	390 Min	22 % Min	50 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 – 90
3.15 x 450	5	20		100 – 130
4.00 x 450	5	20		140 – 190
5.00 x 450	5	20		190 – 240