

ROYAL THERM (Ni) SPL (E 8018 G)

AWS : SFA 5.5, E 8018 G IS : 1395E 55 BG1Ni26 EN ISO 2560 A E 46 5 1Ni B 12 H5

Applications

Welding of high strength steel, heavy duty structural fabrication, fine grained, Q & T steel, pressure vessels, tanks, Penstocks.

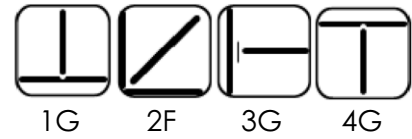
Characteristics on Usage

A basic coated low hydrogen iron powder type electrode. it is used for welding heavy section of fine grained, high strength steel. It's running very smooth and easy slag removable, yielding a weld deposit containing 1.50%Mn and 0.7%Ni. it gives radiographic quality and low temperature service down to minus 60oC.

Notes On Usage

- ⚡ Dry the electrodes at 250 - 300°C for 60 min before use.
- ⚡ Keep the arc as short as possible.
- ⚡ Adopt back step method or strike the arc on a small plate prepared for this particular purpose because arc striking on the base metal is in danger of initiating cracking.

Welding Positions



Approvals

E.I.L

LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%
0.10 Max	1.00 Min	0.80 Min	0.030 Max	0.030 Max	0.30 Min	0.50 Min	0.20 Min

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 50 o C (J)	Hydrogen (Mercury method) in 100gm weld metal	Reduction Area%
550 Min	460 Min	19 % Min	40 Joules Min	5 ml (Max)	50 - 80

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		90 - 120
4.00 x 450	5	20		110 - 150
5.00 x 450	5	20		150 - 200