

ROYAL 9018 (E 9018G)

AWS : SFA 5.5, E 9018G IS : 1395E 63 BG129Fe EN ISO 2560 A E 52 5 Z B 32 H5

Applications

Welding of grain refined steels. Q&T steel, HSLA steel, and ASTM A615 Grade 60 steel, structural fabrication, Penstocks, Tanks, pressure vessels.

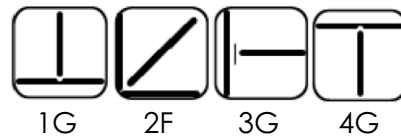
Characteristics on Usage

A heavy coated low hydrogen iron powder type electrodes , welding in all positions used for welding steel having high tensile strength upto 70 Kg/mm² as well as low alloy structural steel. The weld is of radiographic like quality having excellent welding characteristics like crack

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 ar striking o the base metal is in danger of initiating cracking.

Welding Positions



LOW ALLOY HIGH TENSILE ELECTRODES

Chemical Composition Of Weld Metal

| C% | Mn% | Si% | S% | P% | Ni% | Mo% |
|----------|----------|----------|-----------|-----------|----------|----------|
| 0.10 Max | 1.70 Max | 0.80 Max | 0.030 Max | 0.030 Max | 1.40 Max | 0.50 Max |

Mechanical Properties Of Weld Metal

| U.T.S. (N/mm ²) | Y.S. (N/mm ²) | ELONGATION (L = 4d) % | IMPACT (CVN) AT - 51 o C (J) | HARDNESS |
|--------------------------------|------------------------------|----------------------------|-----------------------------------|-------------|
| 630 Min | 550 Min | 20 % Min | 40 Joules Min | 200 BHN Max |

Packing and Welding Current

| SIZE (mm) | KG PER PACKET | KG PER CARTON | Current (Amps) | In Amps |
|-------------|---------------|---------------|----------------|-----------|
| 2.50 x 350 | 5 | 20 | AC / DC (+) | 70-100 |
| 3.15 x 450 | 5 | 20 | | 100-140 |
| 4.00 x 450 | 5 | 20 | | 140-180 |
| 5.00 x 450 | 5 | 20 | | 180 - 230 |