ROYAL THERM (2H) SPL (E 7018 (NACE))

AWS : SFA 5.1, E 7018 NACE IS : 814 E611514 HJ EN ISO 2560 A E 42 3 B 32 H5

LOW HYDROGEN TYPE ELECTRODES

Applications

Tanks and pressure vessels, Heavy Machinery, Bridges, Penstocks, Carbon steel & Low alloy steel fabrication with stand high temperature service condition and also for joining heavy parts of earthmoving equipments.

Characteristics on Usage

A heavy coated iron powder type all position electrode for welding of high tensile, heavy sections, structural steel and restrained joints in high tensile steels. It gives smooth arc, medium penetration and detach the slag easily in a Vee grove joint. The electrode is used for critical welding and gives excellent welding characteristics, the weld metal contains 1.20% Mn and controlled Sulphur as well as Hydrogen which is extremely resistant to cold and hot

Approvals

E.I.L.,IOCL

Welding Positions

1G 2F 3G 4G

Notes On Usage

- Dry the electrode a 300-350 °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 stricking o the base metal is in danger of initing cracking.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	1.60 Max	0.50 Max	0.012 Max	0.015 Max	0.20 Max	0.30 Max	0.30 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm^2)	Y.S. (N/mm^2)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)	Hydrogen content in 100grm weld metal
500 Min	400 Min	22 % Min	50 Joules Min	4 ml 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 350	5	20		80 – 140
4.00 x 350	5	20		140 – 180
5.00 x 350	5	20		180 – 230
6.30 x 350	5	20		230 - 280