

ROYAL THERM (E 7018)

AWS : A 5.1, E 7018 IS : 814 EB 5426H3JX EN ISO 2560 A E 42 3 B 32 H5

Applications

Ship Building, Pipelines, Bridges, Boilers, Pressure Vessels, Restrained Joints, Penstocks, Blast Furnace Steel Work, Atomic Reactor Shell & Pipework.

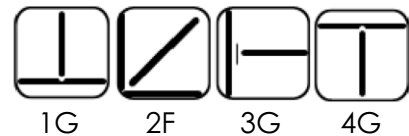
Characteristics on Usage

This is a basic heavy coated low hydrogen iron powder type electrode with excellent weld characteristic. very smooth arc, medium penetration and low spatter, easy to remove slag. the weld metal is ductile and crack resistant and is of radiographic quality. it is easy to operate in all position and deposition efficiency is approximately 115%. (PLEASE KEEP DRY)

Approvals

L.R.S, I.R.S, I.B.R, P.D.I.L, B.V., B.I.S. [ISI], E.I.L, TOYO [TEIL], RPL-BECHTEL, THERMAX, L & T, I.P.C.L, K.PG.I.L, I.O.C.L, M.R.P.L, M.M.D., UDHE INDIA LTD. , B.H.E.L., B.H.P.V., ABS, DNV, NPCIL, M.N.DASTUR & CO., RDSO CLASS A4 B2, SUZLON ENERGY, TPL

Welding Positions



Notes On Usage

- ⚡ Dry the electrode at 300-350 °C for 60 Min- before use .
- ⚡ Keep the arc as short as possible
- ⚡ Use wind screen against strong wind.

LOW HYDROGEN TYPE ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 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)	RADIOGRAPHY TEST	Hydrogen (Mercury method) in 100gm weld metal
490 Min	400 Min	22 % Min	27 Joules Min	Satisfactory as per IIW blue std	5 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 70 OCV/ DC+	60 - 95
3.15 x 450	5	20		90 - 120
4.00 x 450	5	20		140 - 190
5.00 x 450	5	20		190 - 250
6.30 x 450	5	20		250 - 310