

CLASSIFICATION

AWS A 5.1	IS 814	BS 639	DIN 1913
E7018-1H4R	EB 5629H ₃ JX	E 5156B12024(H)	E 5156B1026



CHARACTERISTICS

The electrode has basic heavy coated low hydrogen with iron powder compound which permits deposition efficiency of 115% approx. It gives stable arc, low spatter, and smooth weld beads with easily detachable slag. The weld metal is radiographic quality with excellent mechanical properties even at minus 46°C. The electrodes are easy to operate in all positions for pipe welding in 5G & 6G.

APPLICATIONS

This type of electrode are widely used for heavy restrained joints subject to dynamic loading, welding of C-Mn steels boilers, pressure vessels, bridges, spheres, storage tanks and piping used for sour gas service, earth moving equipment, blast furnace shells, pipelines and heavy structures for ship building and ship repair application etc.

Note: Available in Vacuum Pack .Please Re dry the electrode at 300°C for one hour .If the packet is open for 12 hours or more ,5 times max.

WELDING POSITION



1G



2F



3G



4G



5G



6G

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENT	C	Mn	Si	S	P
PERCENT (max) :	0.08	1.10 - 1.60	0.40	0.025	0.025

Diffusible Hydrogen level: < 4.0 ml/ 100g weld metal.

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

YS (N/mm ²)	UTS (N/mm ²)	Elongation in %	CVN Impact at -46°C (Joules)
450 - 510	510 - 640	25 - 30	50 - 150

CURRENT CONDITION : AC (OCV-90V) / DC (+)

SIZE(mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
CURRENT (amps)	60 - 90	100 - 140	150 - 190	180 - 240

PACKING DETAILS

DIA (mm)	Ø 2.50	Ø 3.20	Ø 4.00	Ø 5.00
LENGTH (mm)	350	350/450	450	450
WEIGHT /PKT (Kg)	5	5	5	5
PKT / BOX	4	4	4	4
WEIGHT /BOX (Kg)	20	20	20	20

BASE MATERIALS STEELS UP TO A YIELD STRENGTH OF 420 N/MM2 (60 KSI)

S235JR-E335, S235J2G3 - S355J2G3, C22, P235T1-P355T1, P235T2, P355T2, L210 - L360NB L290MB - L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1 - S235J4S, S355G1S - S355G3S, S255N - S355N, P255NH-P355NH, S255NL - S355NL, GE200-GE260, GE300 ASTM A 27 a. A36 Gr. all; A214; A 242 Gr. 1-5; A266 Gr. 1, 2, 4; A283 Gr. A, B, C, D; A285 Gr. A, B, C; A299 Gr. A, B; A328; A366; A515 Gr. 60, 65, 70; A516 Gr. 55; A570 Gr. 30, 33, 36, 40, 45; A 572 Gr. 42, 50; A606 Gr. all; A607 Gr. 45; A656 Gr. 50, 60; A668 Gr. A, B; A907 Gr. 30, 33, 36, 40; A841; A851 Gr. 1, 2; A935 Gr. 45; A936 Gr. 50; API 5 L Gr. B, X42 - X56