

**ROYAL 7018 C3L (AWS:SFA 5.5, E 7018 C3L)**

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**Applications**

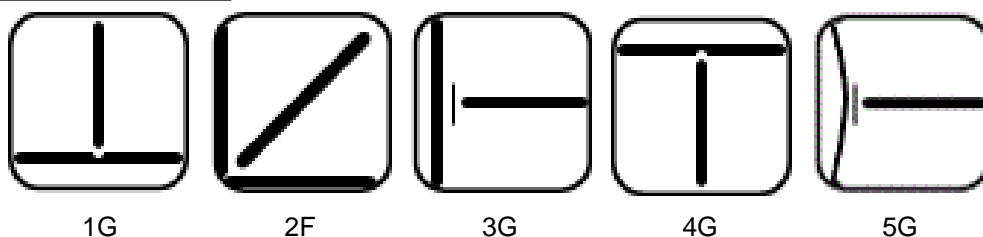
It is used for welding of nickel alloy piping, system valves and tanks. Used for welding low temperature service for Locomotive main frames, Refineries, Pipelines, Equipments, fabrication of pressure vessels.

**Characteristics on Usage**

A medium heavy coated low hydrogen iron powder type electrodes. the weld metal deposits 1.0 % Ni in the weld metal. It is specially designed for welding fine grained steel, nickel alloy steel. It gives high ductility , toughness and resistance to the service temperature at minus 50 °C

**Notes On Usage**

- 1) Dry the electrode at 250 °C for 60 Min- before use .  
2) Keep the arc as short as possible.

**Welding Positions**

1G

2F

3G

4G

5G

**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.08 Max	0.40 - 1.40	0.50 Max	0.030 Max	0.030 Max	0.15 Max	0.80 - 1.10	0.35

**Mechanical Properties Of Weld Metal**

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT - 50 ° C ( J )
490 Min	390 Min	22 Min	27 Min

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50X350	150	600	AC/DC (+)	60-90
3.15X450	100	400		100-140
4.00X450	70	280		140-180
5.00X450	45	180		180-250