

**ROYAL THERM SPL H4R (E 7018-1 H4 R)**

AWS : SFA 5.1, E 7018-1 H4 R

**Applications**

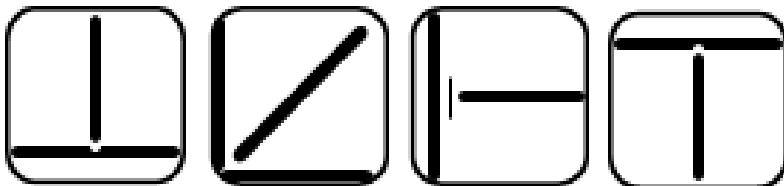
All maintenance application including welding of all types of Carbon-manganese steel, high tensile steel, heavy structure, plant and equipments subject to static or dynamic loading. Can be used as a buffer layer before hardfacing.

**Characteristics on Usage**

hydrogen controlled, vacuum packed, basic coated electrodes which is welder friendly and is recommended for welding of mild steel, medium carbon, steel, high strength steel, cast steel and problematic steels. The electrodes is vacuum packed and hence does not require expensive redrying at 250oC for 2 hours or a higher temperature. The weld metal is clean and has lowest level of impurities with has much longer life than the weld metal usually deposited with other E 7016 or E 7018 class of electrodes. Deposited weld metal met X-ray radiographic quality standards. The

**Notes On Usage**

- 1) Dry the electrode a 300-350 °C for 60 Min- before use .
- 2) Keep the arc as short as possible.
- 3) Use wind screen against strong wind.

**Welding Positions**

1G

2F

3G

4G

**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

**Mechanical Properties Of Weld Metal**

U.T.S.	Y.S.	ELONGATION	IMPACT ( CVN )	Hydrogen content
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT - 45° C ( J )	in 100 gm weld metal
490 Min	400 Min	22 % Min	27 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 (+)	70-90
3.15 x 450	5	20		100-130
4.00 x 450	5	20		140-190
5.00 x 450	5	20		190-240

**Packing**

Vaccum packing