ROYAL MOLY THERM - SPL (E 8018 D3)

AWS : SFA 5.5, E 8018 D3

Applications

For welding 0.9% N & 0.5 Mo steel boiler tubes & boiler Plates etc. Suitable for welding of manganese molly steel. Low alloy high tensile

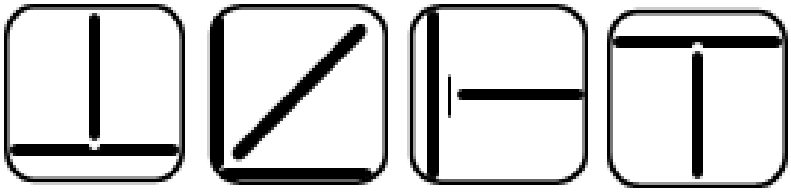
Characteristics on Usage

It is a medium heavy coated Hydrogen Controlled iron powder type all position electrodes deposit low alloy steel weld metal having 0.90% Ni & 0.50% Mo. Gives smooth arc, little spatter & easily removable slag. Specially suitable for the welding of Manganese molly steel and similar composition. The weld is of radiographic quality. Redry electrodes at 250o C for one hour for better result.

Notes On Usage

- 1) Dry the electrode a 350-400 °C for 60 Min- before use .
- 2) Preheat at 100 - 200 °C & post heat at 620 ± 15 °C
- 3) Keep the arc as short as possble.

Welding Positions



1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni %	Mo %
0.12 Max	1.0-1.75	0.80	0.030 Max	0.030 Max	0.90 Max	0.25-0.45

Mechanical Properties Of Weld Metal

U.T.S. (N/mm²)	Y.S. (N/mm²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT – 50 º C (J)
560 – 660	460 – 570	19 %	27 Joules Min

Approvals

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 X 350	150	600	AC / DC (+)	70 – 90
3.15 X 450	100	400		90 – 130
4.00 X 450	70	280		140 – 180
5.00 X 450	45	180		180 – 220