

**ROYAL THERM – (SPL) (E 7018 -1)**

AWS : SFA 5.1 E 7018 – 1

IS : 814 EB 5629 H3JX

**Applications**

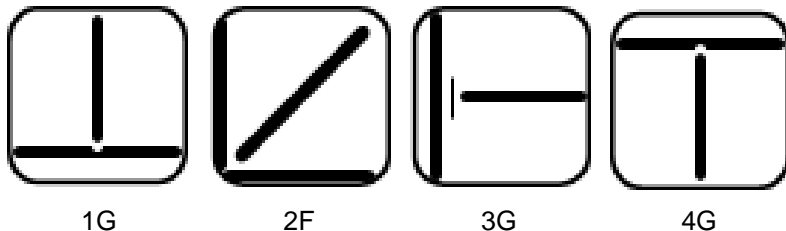
Boilers, Pumps & Compressors, Blast Furnace steel work, Bridges, Rail wagons, Earth Moving Equipment's, Road Building Machinery, Tanks, Pressure Vessels, Penstocks, Atomic Reactor Shell.

**Characteristics on Usage**

This unique electrode is capable of yielding welds which are of Radiographic quality specially designed for high Impact values down to – 46 centigrade and is crack resistant. This electrode has easy slag removal, excellent

**Notes On Usage**

- 1) Dry the electrode at 350-400 °C for 60 Min- before use .
- 2) Keep the arc as short as possible and avoid large width of weaving.
- 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose to prevent blow hole at the arc starting.

**Welding Positions****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	47 Joules Min	5 ml Max

**Approvals**

L.R.S., B.V., P.D.I.L., E.I.L., ABS, NPCIL, I.B.R., DNV, MRPL, BHEL, APG I L, IOCL, L&T, TPL UDHE INDIA LTD,

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	200	800	AC / DC (+)	80 – 100
3.15 x 450	100	400		100 – 135
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 250
6.30 x 450	30	120		250 – 320