

**ROYAL THERM (2H) SPL (E 7018 (NACE))**

AWS : SFA 5.1, E 7018 NACE

IS : 814 E611514 HJ

**Applications**

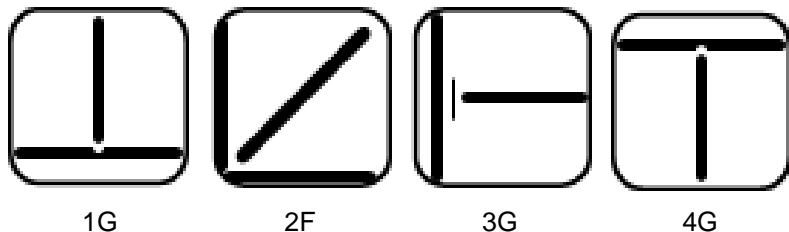
Tanks and pressure vessels, Heavy Machinery, Bridges, Penstocks, Carbon steel & Low alloy steel fabrication with stand high temperature service condition and also for joining heavy parts of earthmoving equipments.

**Characteristics on Usage**

A heavy coated iron powder type all position electrode for welding of high tensile, heavy sections, structural steel and restrained joints in high tensile steels. It gives smooth arc, medium penetration and detach the slag easily in a Vee groove joint. The electrode is used for critical welding and gives excellent welding characteristics, the weld metal contains 1.20% Mn and controlled Sulphur as well as Hydrogen which is extremely resistant to cold and hot

**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****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.10 Max	1.60 Max	0.50 Max	0.012 Max	0.015 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 - 30° C ( J )	in 100 gm weld metal
500 Min	400 Min	22 % Min	50 Joules Min	4 ml Max

**Approvals**

E.I.L.,IOCL

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	200	800	AC / DC (+)	70 – 100
3.15 x 450	100	400		80 – 140
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 230
6.30 x 450	30	120		230 - 280