ROYAL THERM (Ni) SPL (E 8018 G)

AWS : SFA 5.5, E 8018 G
IS : 1395E 55 BG1Ni26

Applications

Welding of high strength steel, heavy duty structural fabrication, fine grained, Q & T steel, pressure vessels, tanks, Penstocks.

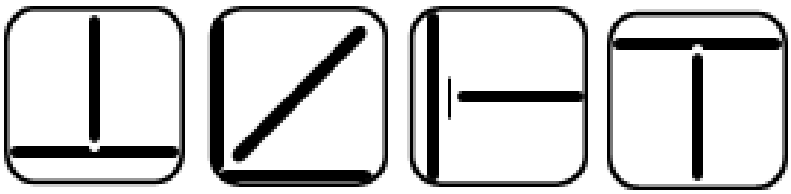
Characteristics on Usage

A basic coated low hydrogen iron powder type electrode. it is used for welding heavy section of fine grained, high strength steel. It's running very smooth and easy slag removable, yielding a weld deposit containing 1.50%Mn and 0.7%Ni. it gives radiographic quality and low temperature service down to minus 60ºC.

Notes On Usage

- 1) Dry the electrodes at 350 -400°C for 60 min before use.
- 2) Keep the arc as short as possible .
- 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose because arc stricking on the base metal is in danger of initating cracking.

Welding Positions



1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.10 Max	1.00 Min	0.80 Min	0.030 Max	0.030 Max	0.30 Min	0.50 Min	0.20

Mechanical Properties Of Weld Metal

U.T.S. (N/mm²)	Y.S. (N/mm²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT – 50 º C (J)	Hydrogen (Mercury method) in 100grm weld metal	Reduction Area %
550 Min	460 Min	19 % Min	40 Joules Min	5 ml (Max)	50 - 80

Approvals

E.I.L

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 – 90
3.15 x 450	100	400		90 – 120
4.00 x 450	70	280		110 – 150
5.00 x 450	45	180		150 – 200