

**ROYAL THERM - 110M (E 11018M)**SFA 5.5 AWS E 11018M  
IS : 814E 76BM329Fe**Applications**

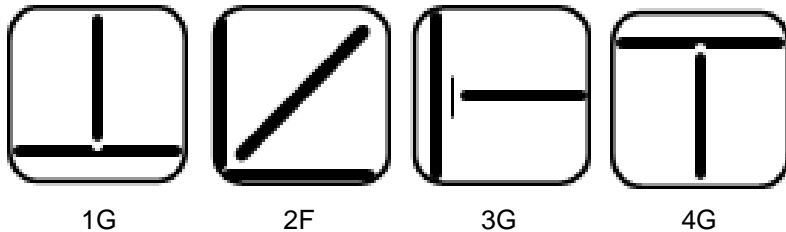
Welding of Penstocks, Earth moving equipments, Heavy duty structure made from high tensile steel. Petrochemicals Tanks & Vessels.

**Characteristics on Usage**

A basic coated low hydrogen iron powder type electrode used for welding high strength steel. the electrode is operating in all position and has excellent welding characteristics. the weld metal is of radiographic quality and possesses high strength combined with excellent toughness at sub Zero temperature. it is used for welding high tensile fine grained steel.

**Notes On Usage**

- 1) Dry the electrodes at 350 -400°C for 60 minutes before use
- 2) Preheat at 150 - 200 °C
- 3) Keep toe area as short as possible

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.10 Max	1.30 -1.80	0.60 Max	0.030 Max	0.030 Max	0.40 Max	1.25 - 250	0.25 -

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT (CVN) AT - 50 ° C ( J )
760 Min	680 Min	20 % Min	27 Joules Min

**Approvals**

E.I.L.

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	60 – 90
3.15 x 450	100	400		100 – 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