

# ROWELD-18 SPL

HYDROGEN CONTROLLED, BASIC COATED, IRON  
POWDER TYPE ELECTRODE FOR OUTSTANDING  
TOUGHNESS IMPACT PROPERTIES

BASIC ALLOY: FE, MN, SI  
AWS/SFA-5.1: E 7018  
EN ISO 2560-A E 42 4 B 32

## KEY FEATURES:

An iron powder, hydrogen controlled electrode producing tough & ductile weld metal for welding heavy & rigid structure subjected to dynamic loading. The weld metal is of radiographic quality and displays remarkable mechanical properties like toughness resistance even at -50°C temperature

## APPLICATIONS

- Suitable for high pressure boilers vessels.
- Carbon steel rigid and heavy structures.
- Steels sensitive to hydrogen embrittlement and prone to crack.
- Industrial equipment subjected to severe impact.
- off-shore drilling rigs and flat forms
- Equipment's require heavy impact at minus 46°C.
- Thick plate of carbon steels

## RE-DRY CONDITION:

- Re-Dry the electrode at 250°C-300°C for one hour before use

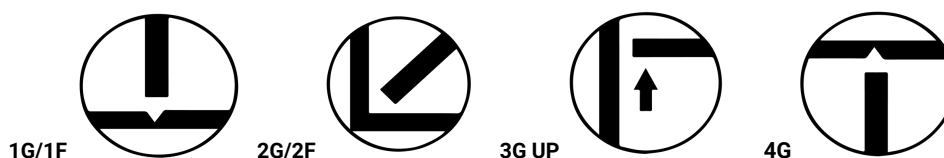
## CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.10 max	1.00-1.60	0.50 Max	0.030 Max	0.030 Max

## MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
460-520	520-620	24-32	-46C : 50-80J

## WELDING POSITION



## DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (DXL)	Size (inch) (DXL)	Current Condition (DC+/AC 90V)	Kg./pkt.	KG/Case
2.50/ 2.40	3/ 32"	80-100	5	20
3.15/ 3.20	1/ 8"	110-140	5	20
4.00	5/ 32"	150-180	5	20
5.00	3/ 16"	210-260	5	20