

ROWELD-18

A HEAVY COATED, HYDROGEN CONTROLLED, BASIC COATED, IRON POWDER TYPE ELECTRODE

BASIC ALLOY: FE, MN, SI
AWS/SFA-5.1: E 7018
EN ISO 2560-A E 42 3 B 32

KEY FEATURES:

A Heavy coated, hydrogen controlled, basic coated, iron powder type electrode specially designed for restrained joints subjected to dynamic loading and to achieve minimum 110% metal recovery, possess, excellent mechanical properties, weld deposits are highly ductile, crack resistant and of radiographic quality

APPLICATIONS

- 1) Blast furnace, Offers Drilling rigs and flat forms.
- 2) Penstocks heavy structures subjected to dynamic loading and impact.
- 3) Rail wagons, coaches.
- 4) Industrial & mining machinery, bridges, boiler fabrication.
- 5) Steels subjected to service at -30°C down sub-zero temperature.
- 6) Machinery for Earth moving and road equipment's.
- 7) Atomic reactor shell and pipe work.
- 8) Frigates & submarines

RE-DRY CONDITION:

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

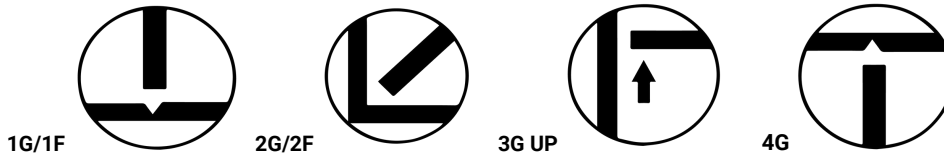
CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.10 max.	0.80-1.60	0.75 Max	0.030 Max	0.030 Max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
450 Min.	510-620	22 min	-30C : 60-100 J

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC±/AC) Amps	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40	3/ 32"	70-100	5	20
3.15/ 3.20	1/ 8"	100-130	5	20
4.00	5/ 32"	140-180	5	20
5.00	3/ 16"	190-230	5	20