

# ROWELD-18M

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

BASIC ALLOY: FE, MN, SI, MO  
AWS/SFA-5.5: E 7018 A1  
EN ISO 3580 E MO B 32

## KEY FEATURES:

An iron powder, hydrogen controlled medium heavy coated electrode producing 0.50% Mo weld deposit. Electrode has high welding efficiency coupled with creep resistance properties at 525°C temperature and has excellent mechanical properties

## APPLICATIONS

- Suitable for high pressure boiler tubes and plates. Fabrication for welding 0.50% Mo and 1% Cr-0.5% Mo steels used for elevated temperature services up to 525°C. Suitable for fine grained and creep resistant steel welding.

## RE-DRY CONDITION:

- Re-Dry the electrode at 350°C for one hour before use.

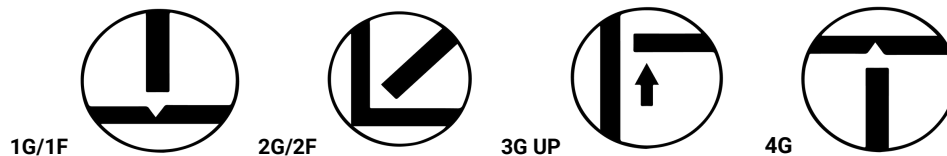
## CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Mo
0.12 max.	0.90 Max	0.60 Max	0.030 Max	0.40-0.65

## MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
390 Min.	490 Min	22 min	+27C : 140 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