

ROWELD-8018 (NI)SPL

BASIC TYPE, IRON POWDER TYPE ELECTRODE YIELDING
A WELD METAL CONTAINING 1.5MN AND 0.7NI.

BASIC ALLOY: FE, MN, SI, NI
AWS/SFA-5.1: E8018-G
EN ISO 2560-A-E 46 5 1NI B 12

KEY FEATURES:

ROWELD-8018 (Ni) Spl is an iron powder low hydrogen type electrode, and provides good usability with direct current applications in all-positions. The weld metal has good crack resistability and X-ray soundness. Also it is suitable for multi-layer fillet welding in large leg length.

APPLICATIONS

- 1. Welding of 55kgf/mm² class high tensile strength steel for ships, bridges, buildings, and boilers
- 2. Welding of ALDUR 45/60, ASTM SA-841/841M
- 3. Joining steels containing 1% Ni

RE-DRY CONDITION:

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

CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni
0.12 max	1.3-1.80	0.60 Max	0.020 Max	1.00 Max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
460 min.	550 min.	22 Min.	51C : 30-60J

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DIA)	Size(inch) (DIA)	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