

ROWELD-8018 D3

EXTRA LOW HYDROGEN CONTROLLED ELECTRODE
YIELDING A WELD DEPOSIT CONTAINING MN-MO

BASIC ALLOY: FE, MN, SI, MO, NI
AWS/SFA-5.1: E8018-D3

KEY FEATURES:

Extra Low Hydrogen type, Medium-heavy coated electrode Mn-Mo type low alloy steel welds, Exhibit good toughness at subzero temperatures, all position capability Weld metal gives radiography quality, ultrasonic and other code requirements Suitable for fully killed fine grained steels,

APPLICATIONS

- 1. Suitable for Welding of Mn-Mo type steels and equivalent grades Penstocks,
- 2. Pressure vessels Welding low alloy high strengths steels in 540 MPa UTS range
- 3. Earth moving equipment's

RE-DRY CONDITION:

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

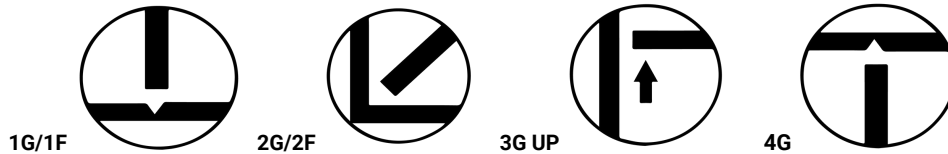
CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni	Mo
0.12 max	1.00-1.80	0.80 Max	0.020 Max	0.90 Max	0.40-0.65

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
460 min.	550 min.	19 Min.	51C : 30-60J

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