ROWELD-HTH4R

BASIC-TYPE HYDROGEN CONTROLLED ELECTRODE FOR WELDING HIGH TENSILE STRUCTURAL STEEL

BASIC ALLOY: FE, MN, SI, NI, CR
AWS/SFA-5.5: E 9018 G H4R
EN ISO 18275-B E 62 18-G A H5

KEY FEATURES:

A basic type, medium-heavy coated, hydrogen-controlled iron powder electrode for heavy-section, constrained joints in high-tensile structural steels.

APPLICATIONS

- Welding high tensile steels.
- Oil refinery components
- Structural fabrication
- Equipment such as penstocks to be subjected to -50°C
- Power house construction
- Boiler fabrication

RE-DRY CONDITION:

- No need of drying. The electrodes are vacuum packed hence can be used straight on the job.

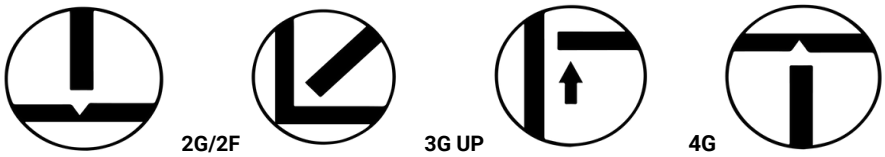
CHEMICAL COMPOSITION:

C	Mn	Si	Ni	Mo	S&P
0.10 max	1.20-1.80	0.50 Max	0.80-1.50	0.60 Max	0.025 Max

MECHANICAL PROPERTIES:

YS (N/mm2)	UTS (N/mm2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT	Hydrogen contains
520min.	620min.	17 min	-50C: 50-80 Joules	less than 4mL/100g

WELDING POSITION



1G/1F 2G/2F 3G UP 4G

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (DIA)	Size (inch) (DIA)	Current Condition (DC+/AC 70V) Amps	Kg./pkt.	KG/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