

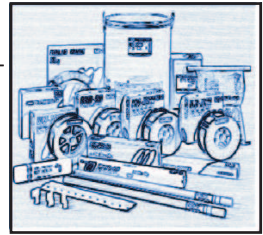
Shielded Metal Arc Welding

ANU BOND - 18/8/5 (E 18: 8Mn R26)

IS:5206 E 18.8 Mn R 26

Application :

Suitable for joining ferritic to austenitic steels, Armour plates .heat resistant steels, dissimilar materials. Buffers layers on difficult steels before hardfacing. Excellent for repairing cracks in austenitic Mn steel, casting for surfacing manganese steel.



Characteristics on Usage :

It is a light -basic coated multi purpose stainless steel electrode with S.S corewire , easy to operate in all position at low current. The weld metal has excellent crack resistance as heat resistance at 900oC. It is also corrosion resistant to atmosphere, marine water and weak acids. It gives 18% Cr, 8% Ni, 5% Mn type weld deposit, easily removable slag. It is to be dried at 250oC for 1 hour before welding.

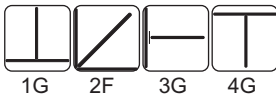
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo
0.20 Max	5.0-8.0	0.90 Max	0.030 Max	0.040 Max	17.0-20.0	7.0-10.0	0.50 Max

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Elongation (L=5d) %
560- 670	30- 40

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	DC (+)/ 70 OCV	50-75
3.15 x 350	2	12		80-110
4.00 x 350	2	12		110-150
5.00 x 350	2	12		150-200

