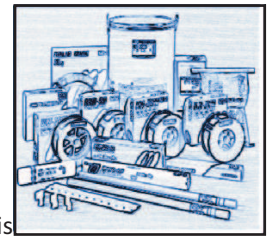
Shielded Metal Arc Welding

ANU BOND THERM H4R (E 7018 H4R)

AWS: SFA 5.1,E 7018 H4 R



Application :

All maintenace application including welding of all types of Carbon-Manganese steel, high tensile steel, heavy structure, plant and equipments subject to static or dynamic loding. Can be used as buffer layer befor hardfacing.

Characteristics on Usage :

The low hydrogen controlled,vacuum packed, basic coted electrodes which is welder friendly and is recommended for welding of mild steel, mwdium carbon,steel, high strength steel, cast steel and problematic steel. The electrodes is vacuum packed and hence does not require expensive redrying at 250oC for 2 hoursor a higher temprature. The weld metal is clean and has lowest level of impurities with has much longer life than the weld metal usally deposited with other E 7016 or E 7018 class of electrodes. Deposited weld metal met X-ray radio-graphic quality standerds. The electrode can be used in all positions of welding and ideally suited for pipe welding including 5G, 6G and 6GR positions

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

C	Mn	Si	S	P	Cr	Ni	Mo	V
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30 Max	0.08 Max

Mechanical properties of all-weld metal as per AWS

UTS	Y. S.	Elongation	*Impact*	Hydrogen content
(N/mm^2)	(N/mm^2)	(L=4d) %	(CVN) AT $+27^0$C (J)	in 100grm weld metal
490 Min	400 Min	22 % Min	27 Joules Min	4 ml (Max)

Welding Positions

Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2.50 Kg	12.5 Kg	AC/ DC (+)	70-90
3.15 x 450	3 Kg	15 Kg		100-130
4.00 x 450	3 Kg	15 Kg		140-190
5.00 x 450	3 Kg	15 Kg		190-240