

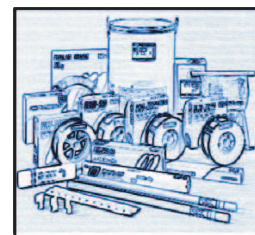
Shielded Metal Arc Welding

ANU BOND THERM SPL H4R (E 7018-1 H4R)

AWS: SFA 5.1, E 7018-1 H4 R

Application :

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



Characteristics on Usage :

Hydrogen controlled, vacuum packed, basic coated electrodes which is welder friendly and is recommended for welding of mild steel, medium carbon steel, high strength steel, cast steel and problematic steel. The electrodes are vacuum packed and hence do not require expensive redrying at 250°C for 2 hours or a higher temperature. The weld metal is clean and has the lowest level of impurities with a much longer life than the weld metal usually deposited with other E 7016 or E 7018 class of electrodes. Deposited weld metal meets X-ray radiographic quality standards. The electrode can be used in all positions of welding and is 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 (N/mm ²)	Y. S. (N/mm ²)	Elongation (L=4d) %	Impact (CVN) AT +27 ⁰ C (J)	Hydrogen content in 100gm 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

