

**Shielded Metal Arc Welding**

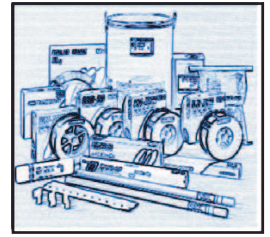
**ANU BOND Therm-(SPL) (E 7018-1)**

AWS: SFA 5.1 E7018 - 1 IS :814 EB5629 H3JX

Low Hydrogen Type Welding Electrodes

**Application :**

Boilers, Pumps & Compressor, Blast Furnace steel work, Bridges, Rail wagons, Earth Moving Equipment's, Road Building Machinery, Tanks, Pressure Vessel, Penstocks, Atomic Reactor Shell.



**Characteristics :**

This unique electrodes is capable of yielding welds which are of Radiographic quality specially designed for high impact values down to -46 centigrade and is crack resistant. This electrode has easy slag removal, excellent arc stability and arc smoothness.

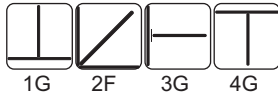
**Chemical composition of All-Weld metal (%) as per AWS**

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

**Mechanical properties of all-weld metal as per AWS**

UTS	YS	Elongation	Impact	Hydrogen content
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L=4d ) %	(CVN) at - 45 °C (J)	in 100 gm weld metal
490 Min	400 Min	22.0% Min	47 Joules Min	5 ml Max

**Welding Positions**



**Packaging & Welding Current**

SIZE (mm)	Kg Per Packet	Kg Per Carton	Current (Amps)	In Amps
2.50 x 350	3	15	AC/ DC (+)	80-100
3.15 x 450	3	15		100- 135
4.00 x 450	3	15		140- 180
5.00 x 450	3	15		180- 250

