

Shielded Metal Arc Welding

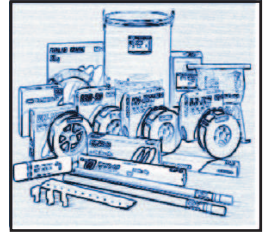
ANU BOND Therme (E 7018)

AWS: SFA 5.1 E7018 IS :814 EB5426 H3JX

Low Hydrogen Type Welding Electrodes

Application :

Ship Building, 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 is a basic heavy coated low hydrogen iron powder type electrode with excellent weld characteristics. Very smooth arc, medium penetration & low spatter, easy to remove slag. The weld metal is ductile & crack resistant & is of radiographic quality. It is easy to operate in all position & efficiency is approximately 115%.

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

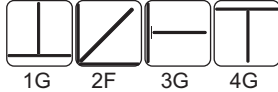
Mechanical properties of all-weld metal as per AWS

UTS	YS	Elongation	Impact	Hydrogen content
(N/mm ²)	(N/mm ²)	(L=4d) %	(CVN) at - 30 °C (J)	in 100 gm weld metal
490 Min	400 Min	22.0% Min	27 Joules Min	5 ml Max

Approvals

IRS , IBR

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

