

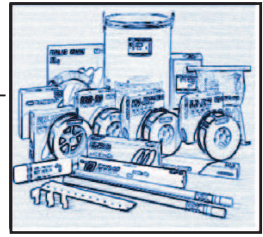
Shielded Metal Arc Welding

ANU BOND THERM (2H)SPL (E 7018(NACE))

AWS: SFA 5.1,E 7018 NACE,IS:814 E611514 HJ

Application :

Tanck and pressure vessels, Heavy machinery, Bridges, Penstocks, Carbon steel & Low alloy steel fabrication with stand high temperature service condition and also for joining heavy part of erthmoving equipment.



Characteristics on Usage :

Aheavy coated iron powder type all position electrode for welding of high tensile, heavy section, structural steel and restrained joints in high tensile steel. It gives smooth arc, medium penetration and detach the slag easily in a Vee groove joint. The electrode is used for critical welding and gives excellent welding characteristics, the weld metal contains 1.20% Mn and controlled Sulpher as well as Hydrogen whichis extremely resistant to cold and hot cracking. The welds are of radiographic quality.

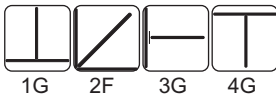
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo	V
0.10 Max	1.60 Max	0.50 Max	0.010 Max	0.015 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 100grm weld metal
500Min	400 Min	22 % Min	50 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 (+)	70-100
3.15 x 450	3 Kg	15 Kg		80-140
4.00 x 450	3 Kg	15 Kg		140-180
5.00 x 450	3 Kg	15 Kg		180-230

