

RATNA 7018 M

Low Alloy Electrodes for Low Temperature services

CLASSIFICATION : AWS/SFA-5.5: E 7018 A1
IS-1395: E 49BA 126Fe

APPROVAL :

CHARACTERISTICS : An iron powder, hydrogen controlled medium heavy coated electrode producing 0.50% Mo weld deposit. Electrode has high welding efficiency coupled with creep resistance properties at 525°C temperature and has excellent mechanical properties.

APPLICATION :

- 1) Suitable for high pressure boiler tubes and plates.
- 2) Fabrication for welding 0.50% Mo and 1% Cr-0.5% Mo steels used for elevated temperature services up to 525°C.
- 3) suitable for fine grained and creep resistant steel welding.

RE-DRY CONDITION : Re-Dry the electrode at 250°C-300°C for one hour, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.12 max.	0.90 Max	0.60 Max	0.030 Max	0.030 Max

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +27 ⁰ C : 140 J (Min.)
390 Min	490 Min	22 Min	

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 70V)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	70-100	165	660
3.15/ 3.20 X 450	1/ 8" X 18"	100-140	110	440
4.00 X 450	5/ 32" X 18"	140-190	75	300
5.00 X 450	3/ 16" X 18"	200-250	55	220

Customer packing on request.