

RATNA-8018 (Ni) spl

Basic coated low Hydrogen type High Tensile Electrode for low temperature service.

CLASSIFICATION : AWS/SFA-5.5: E 8018-G
IS-1395: E 55BG 129Fe

APPROVAL :

CHARACTERISTICS : A basic coated, hydrogen controlled, iron powder electrode depositing 0.65% Ni weld metal with exotic finish and radiographic joints, gives low spatter, smooth arc, also works well to resist atmospheric corrosion.

APPLICATION :

- 1) Suitable for welding on Quenched & Tempered steels.
- 2) Pressure vessels, storage tanks, penstocks, fine grained steels.
- 3) Industrial equipment subjected to sub-zero temperature.
- 4) Other steel categorized for high strength.

RE-DRY CONDITION : Re-Dry the electrode at 300°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Ni
0.10 max.	1.20-1.60	0.60 max	0.030 Max	0.030 Max	0.50-1.00

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
460-550	550-660	22-30	-60 ⁰ C : 40-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+)	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 14"/18"	110-135	110	440
4.00 X 450	5/ 32" X 18"	150-180	75	300
5.00 X 450	3/ 16" X 18"	200-230	55	220

Customer packing on request.