

RATNA-8018 W

Hydrogen controlled low alloy steel electrode designed for welding of weathering steels.

CLASSIFICATION : AWS/SFA-5.5: E 8018 W2
IS-1395: E 55BG 126Fe

APPROVAL :

CHARACTERISTICS : A Hydrogen controlled basic coated electrode for welding weathering steels. Weld metal relatively high resistance to atmospheric corrosion. Very low level of diffusible hydrogen in welds. Weld metal gives radiographic quality.

APPLICATION :

- 1) Suitable for welding of weathering steels like SAILCOR-A & CORTEN A & B steels & equivalent.
- 2) Medium tensile corrosion resistant structure steels and welding of high tensile steels.

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

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Cu
0.12 max.	0.80-1.30	0.35-0.80	0.40-0.70	0.40-0.80	0.30-0.75

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4xd)	CHARPY "V" NOTCH IMPACT AT
460-560	550-670	22-28	-20°C : 50-80 J

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 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.