

# RATNA 7018

## Hydrogen controlled Basic coated Iron powder type Electrode for welding low and high tensile steels.

**CLASSIFICATION** : AWS/SFA-5.1: E 7018 , BS 639 E5144B12024(H)  
IS-814: EB 5426 H3JX, DIN 1913 E 5144B1026

**APPROVAL** : BIS, CIB, IRS, DNV, LLOYARDS, BV, BAX, PDIL, TOYO, BHEL, RDSO (A4),

**CHARACTERISTICS** : A Heavy coated, hydrogen controlled, basic coated, iron powder type electrode specially designed for restrained joints subjected to dynamic loading and to achieve minimum 110% metal recovery, possess, excellent mechanical properties, weld deposits are highly ductile, crack resistant and of radiographic quality.

**APPLICATION** :

- 1) Blast furnace, Offers Drilling rigs and flat forms.
- 2) Penstocks heavy structures subjected to dynamic loading and impact.
- 3) Rail wagons, coaches.
- 4) Industrial & mining machinery, bridges, boiler fabrication.
- 5) Steels subjected to service at -30°C down sub-zero temperature.
- 6) Machinery for Earth moving and road equipments.
- 7) Atomic reactor shell and pipe work.
- 8) Frigates & submarines.

**RE-DRY CONDITION** : Re-Dry the electrode at 250°C-300°C for one hour before use.

**ALL WELD CHEMICAL COMPOSITION %**

C	Mn	Si	S	P
0.10 max.	0.80-1.60	0.75 Max	0.030 Max	0.030 Max

**ALL WELD MECHANICAL PROPERTIES:**

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
450-520	510-620	22-32	-30 <sup>0</sup> C : 60-100 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	170	640
3.15/ 3.20 X 450	1/ 8" X 18"	100-130	110	440
4.00 X 450	5/ 32" X 18"	140-180	72	288
5.00 X 450	3/ 16" X 18"	190-230	50	200

Customer packing on request.