



RASI E 11018 M

premium

BASIC COATED LOW HYDROGEN
ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI E 11018 M is a basic coated, Extra low hydrogen electrode ideally suited for welding of high strength Q & T steels, like WEL - TEN 80, SA 517 grades and their equivalent grades. The weld metal displays excellent crack resistance and produces sound weld possessing excellent strength combined with good impact properties at sub - zero temperature

APPLICATIONS

Pen stock, Earthmoving equipments and other heavy steel fabrications made from high tensile steels for welding of USST-1 steel, Heat treated fine grained steels N-A-XTRA 70, HY 80 etc.

CLASSIFICATIONS

AWS / SFA 5.5 E 11018M
IS : 1395 E76 BM 329Fe

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.10%	Silicon - 0.60%
Manganese - 1.80%	Sulfur - 0.03%
Phosphorus - 0.03%	Cr - 0.40%
Mo - 0.25 - 0.50%	Ni - 1.25 - 2.50%

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 760 MIN.
Yield Strength (N/mm²) - 680 - 760.
Elongation % - 20 %.MIN
CVN Impact at -51°C - 27 J Min.

WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 100 Amps
Ø 3.15 mm - 100 - 140 Amps
Ø 4.00 mm - 140 - 190 Amps
Ø 5.00 mm - 190 - 240 Amps.
Ø 6.30 mm - 240 - 300 Amps.

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

www.rasielectrodes.com

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