

LOW HYDROGEN & LOW ALLOY

RASI E 7018-A1

CREEP RESISTANCE & DUCTILE

CLASSIFICATIONS :

SFA 5.5 AWS E 7018-A1
IS : 1395 E 49B-A1-26Fe

CHARACTERISTICS :

RASI E7018-A1 is a Low Hydrogen and Low Alloy basic coated all position except vertical down welding electrode and it gives the weld metal of ½ % Mo. The weld metal are ductile and creep resistant. The welds are Radio graphically sound.

APPLICATIONS :

The electrodes are well suited for welding of 1Cr - ½ Mo Steels pressure vessels, piping, valves, and tanks used for all refineries and chemical plants etc.

CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENT	C	Mn	Si	Mo	S	P
PERCENTAGE	0.12	0.90	0.80	0.40-0.65	0.03	0.03

MECHANICAL PROPERTIES OF ALL WELD METAL PWHT

UTS (N/mm ²)	YS N/mm ²	Elongation % L = 4D
490 Min	390 Min	25 Min

WELDING CURRENT & PACKING DATA : AC70V/DC(+)

ELECTRODE SIZE, CURRENT RANGE & PACKING

Dia (mm)	2.5 x 350	3.15 x 450	4.0 x 450	5.0 x 450
Current (A)	60-90	100-130	140-180	180-250
Pieces/Pkt/Kg	184/4 Kg	93/4 Kg	60/4 Kg	40/4 Kg
Pkts/Box	4/16 Kg	5/20 Kg	5/20 Kg	5/20 Kg

STORAGE

Re-dry the Electrode at 300°C for 1 Hr, use short arc during welding store the electrode in dry conditions.