

LOW HYDROGEN & LOW ALLOY

**RASI E 8018-C1**

NICKEL ALLOY

**CLASSIFICATIONS :**

SFA 5.5 AWS E 8018-C1  
IS : 1395 E 55 BC1-B1-26 Fe

**CHARACTERISTICS :**

**RASI E 8018 C1** is a Low Hydrogen and Low Alloy basic coated all position electrode and it gives the weld metal 2.5% Nickel imparts a high degree of Low Temperature notch toughness and the resistance to embrittling effects of sub zero temperature at minus 80°C. The welds are Radio graphically sound.

**APPLICATIONS :**

The electrodes are well suited for welding of pressure vessels, piping, valves and tanks used for liquified Ethane, Profane, Butane and Co<sub>2</sub> etc Welding of

**CHEMICAL COMPOSITION OF ALL WELD METAL**

ELEMENTS	C	Mn	Si	Ni	S	P
PERCENTAGE	0.12	0.8-1.25	0.80	2-2.75	0.03	0.03

**MECHANICAL PROPERTIES OF ALL WELD METAL**

UTS (N/mm <sup>2</sup> )	YS N/mm <sup>2</sup>	Elongation % L = 4D	CVN Impact At -59°C
550-660	480-550	22-28	40-80J

Note : Single values shown above are maximum

**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.