

LOW HYDROGEN

RASI E 8018-G

LOW ALLOY

CLASSIFICATIONS :

AWS A 5.5 E 8018G
IS : 1395 E 55 Bg1 26

CHARACTERISTICS :

RASI E 8018 G is a heavy basic coated, all position, except vertical down, low-hydrogen type electrode deposit weld metal of ½ chrome, ½ moly, with vanadium. It gives radiographic quality weld.

APPLICATIONS :

Suitable for welding of boiler and refinery, Chrome moly plates and pipe lines for Welding of

CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENTS	C	Mn	Si	Cr	Mo	S	P
PERCENTAGE	0.10 Max	1.00 Min	0.80	0.30 Min	0.20 Min	0.03	0.03

MECHANICAL PROPERTIES OF ALL WELD METAL PWHT

UTS (N/mm ²)	YS N/mm ²	Elongation %
550 Min	460 Min	19 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	100	60	45	30
Pkts/Box	80	8	8	8

STORAGE

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