LOW HYDROGEN & LOW ALLOY

RASI E 9018 M

CREEP RESISTANCE

CLASSIFICATION :

SFA 5.5 AWS E 9018 M
IS : 1395 E 63BM126 Fe

CHARACTERSTICS :

RASI E 9018 M is Low Hydrogen and Low Alloy High tensile basic Heavy coated all position except vertical down welding electrode and it gives the weld metal of 2% Cr-1 Mo weld deposit. Arc is stable, negligible spatter and easy slag removal. The weld metal are creep resistant up to 600°c. The welds are Radio graphically sound.

APPLICATIONS :

The electrodes are well suited for welding of 2Cr - 1 Mo steels, pressure vessels, piping, valves and tanks used for oil refineries and chemical plants etc.

CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENTS	C	Mn	Si	Ni	Cr	Mo	S	P
PERCENTAGE	0.1	0.6-1.25	0.80	1.4-1.8	0.15	0.35	0.03	0.03

MECHANICAL PROPERTIES OF ALL WELD METAL PWHT

UTS (N/mm^2)	YS N/mm^2	Elongation % L=4d
620 Min	540 Min	24 Min

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.