

CNM (SPL) M

CODIFICATION : AWS : SFA 5.5 E12018M

CHARACTERISTICS AND APPLICATIONS :

- * Basic coated electrode with a stable and smooth arc, easy to strike and restrike.
- * Low spatter and good bead finish.
- * Welds are of radiographic quality.
- * The weld metal displays good crack resistance and produces sound weld metal possessing excellent strength combined with good impact properties at subzero temperature.

It is suitable for joining many high strength, low alloy or micro alloyed steels to themselves or to lower strength steels, including carbon steels. Ideally suited for welding earth moving equipments and other heavy equipments.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

| | | | | | | | | | |
|-----------|------|-----|------|-----|-----|------|-------|-------|------|
| Element : | C | Mn | Si | Cr | Ni | Mo | S | P | V |
| Percent : | 0.07 | 1.6 | 0.35 | 1.0 | 2.2 | 0.40 | 0.012 | 0.020 | 0.03 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

| | | | |
|--------------|-------------|------------------------|---|
| UTS (MPa) | YS (MPa) | Elongation (L= 4d)% | CVN Impact Strength at minus 51°C (Joules) |
| 901 | 792 | 20.0 | 40 |

CURRENT AND PACKING DATA : DC(+)

| | | | | | | |
|-------------------------|---|---------|---------|---------|----------|---------|
| Size (mm) | : | 6.3x450 | 5x450 | 4x450 | 3.15x450 | 2.5x350 |
| Dia x Length | | | | | | |
| Current Range (Amps) | : | 270-320 | 200-250 | 150-190 | 100-140 | 70-100 |
| Qty.(Pcs./Carton) | : | 25 | 35 | 55 | 75 | 125 |

PRECAUTIONS :

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour as per our standard practice.
2. Use short arc and stringer beads.
3. Use a carefully formulated welding procedure with preheat and post weld heat treatment.