



## MOLYTHERME - MOD

**CODIFICATION :** AWS : SFA 5.5 E7018-A1  
IS : 1395 E49 B A1 2 6 Fe

### CHARACTERISTICS AND APPLICATIONS :

Low hydrogen iron powder electrodes depositing 0.5%Mo with excellent toughness. Weld metal retains mechanical properties after prolonged heat treatments. Ideal for welding C-0.5 Mo steels, plates, pipes for pressure vessel, boilers, etc. where toughness at -20°C is required. The weld metal possesses good creep strength up to 525°C.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	S	P	Mo
Percent :	0.06	0.85	0.42	0.015	0.02	0.5

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL: (PWHT : 620°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at minus 20°C (Joules)
525	465	27.0	75

### CURRENT AND PACKING DATA: DC(+)

Size (mm)	: 6.3x450	5x450	4x450	4x350	3.15x350	2.5x350
Dia x Length						
Current Range (Amps)	: 270-320	200-250	140-170	140-180	100-130	70-90
Qty.(Pcs./Carton)	: 25	30	50	50	75	100

### PRECAUTIONS:

1. Rebake the electrodes at 250-300°C for one hour as per our standard recommended practice.
2. Use short arc and stringer bead.