



MOLYTHERME-SPL

CODIFICATION : AWS : SFA 5.5 E9018-D1
IS : 1395 E63BD126

CHARACTERISTICS AND APPLICATIONS :

Extra low hydrogen type electrodes depositing a high strength weld metal. The electrode possesses excellent operating characteristics and is suitable for welding in all positions. Weld metal has got good toughness even at subzero temperatures. Deposition efficiency is about 115%. The weld metal possesses high strength together with good notch toughness even at subzero temperatures down to minus 50°C. Ideally suited for welding fine-grained steels, high strength steels, IS: 8500-91, Gr 540B, 570B, 590B, IS: 2002-92 Gr.3, IS: 1875-92 class 3A or similar.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	Mo	S	P	Ni
Percent :	0.06	1.45	0.50	0.40	0.020	0.021	0.50

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

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	RA%	CVN Impact Strength (J) at	
640	550	23.0	65.0	Minus 50°C	Minus 20°C
				50	120

DIFFUSIBLE HYDROGEN CONTENT : 5 ml/100 gms of weld metal max.

CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	5x450	4x450	3.15x450	2.5x350
Dia x Length					
Current Range	:	200-250	140-190	100-140	80-100
(Amps)					
Qty.(Pcs./Carton)	:	35	55	75	125

APPROVALS: RD & SO Class-C1

PRECAUTIONS:

1. During welding keep the heat input to a minimum.
2. Ensure the electrodes are dry. Rebake electrode at 300°C for one hour before use.