Estd. 1966

DH sécheron

Complete Welding Support

MOLYTHERME

CODIFICATION :

AWS : SFA 5.5 E7018-A1

IS : 1395 E49 B A1 2 6 Fe

CHARACTERISTICS AND APPLICATIONS :

A low hydrogen iron powder type electrode yielding a weld deposit containing 0.5% Mo. Ideal for welding creep resistant C - Mo steels for service temperatures up to 525^{0}C. Typical applications include boilers, pressure vessels, pipes and tubes of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Mo	S	P
Percent	:	0.06	0.85	0.42	0.52	0.025	0.025

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL: (PWHT : 620^{0}C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at 27°C (Joules)	Creep Strength at 525°C (1%offset in 10,000hrs) kgf/mm^2
535	455	28.0	140	12.5

CURRENT AND PACKING DATA: DC(+)

Size (mm) Dia x Length	:	6.3x450	5x450	4x350	3.15x350	2.5x350
Current Range (Amps)	:	270-340	170-240	140-170	90-120	70-90
Qty.(Pcs./Carton)	:	25	35	55	75	125

APPROVALS: Adani Infra, BHEL, CIB-MP, EIL, NPCIL, NTPC, PDIL

PRECAUTIONS:

1. Redry the electrodes as per our standard recommended practice.
2. Use short arc during welding.