



ULTRATENSAL-Cu

CODIFICATION: AWS : SFA 5.5 E10018-G

CHARACTERISTICS AND APPLICATIONS:

Basic coated extra low hydrogen electrode. The weld metal displays excellent crack resistance and produces sound weld metal possessing excellent strength combined with good impact properties at sub-zero temperature. Ideally suited for welding of high strength Q&T steels, like WEL TEN 80, SA 517 grades, WB36 pipes, and their equivalent grades. Welding highly restrained joints in high strength steels under site conditions with relative humidity since the extra low hydrogen content of the weld metal helps preventing hydrogen induced cracking.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	Cu	Ni	Mo	Cr	Nb	Al	S	P
Percent	:	0.08	1.0	0.4	0.6	1.2	0.4	0.2	0.02	0.02	0.014	0.018

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	YS	Elongation
(MPa)	(MPa)	(L= 4d)%
720	620	22

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	180-240	140-180	90-140	50-90
(Amps)					
Weight/carton (kgs)	:	2.5	2.5	2.5	2.5

APPROVALS: Adani Infra, CIB-MP

PRECAUTIONS :

1. Ensure the electrodes are dry. Moist electrodes should be re-dried at 400°C for one hour.
2. Ensure cleanliness of the surface to be welded.
3. Use short arc and minimum heat input. The preheat and Inter pass temperature shall never be more than 150°C