CODIFICATION: AWS : SFA 5.5 E9015-B23 (Old E9018-G)

CHARACTERISTICS AND APPLICATIONS:
✧ A stable and steady arc, which is easy to strike and re-strike. ✧ Easy slag removal and finely rippled smooth beads. ✧ Weld metal of having less impurities i.e. S, P will improve the impact property at subzero temperatures. ✧ Ideally suited for welding creep-resisting steels of similar composition. ✧ Specially applicable wherever prolonged heat treatment cycles are involved. ✧ Ideal for welding P23 material welding.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element : C  Mn  Si  P  S  Cr  Ni  Mo  V  Nb  N  Al  W  Cu  B
Percent : 0.06 0.7 0.30 0.010 0.007 2.2 0.3 0.2 0.2 0.03 0.03 0.02 1.8 0.10 0.004

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT : 740°C FOR 2 HRS)
UTS (MPa)  YS (MPa)  Elongation (L = 4d)%
640  550  22

CURRENT AND PACKING DATA: DC (+)
Size (mm) : 5 x 450  4 x 350  3.15 x 350  2.5 x 350
Dia x Length
Current Range : 180-240  140-180  100-130  70-100
(Amps)
Qty.(Pcs./Carton) : 30  50  75  100

APPROVALS: Adani Infra, Reliance (SASAN Power)

PRECAUTIONS:
1. Use short arc and stringer bead.
2. Ensure the electrodes are perfectly dry.
3. Re-dry the electrodes at 300°C for one hour, as per standard recommended practice.