MOLYHERME (EXTRA)

CODIFICATION: AWS : SFA 5.5 E8018-D3

CHARACTERISTICS AND APPLICATIONS:
Molytherme (Extra) is a low hydrogen electrode yielding a weld deposit containing Mn-Mo. The electrode is ideally suited for welding steels of similar composition. The weld metal possesses good high temperature properties and has excellent toughness.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element : C  Mn  Si  Mo  S  P
Percent  : 0.07 1.25 0.40 0.55 0.015 0.018

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 51°C (Joules)
604         495         25.0               28

CURRENT AND PACKING DATA: DC(+)
Size (mm) : 6.3x450   5x450   4x350   3.15x350   2.5x350
Dia x Length
Current Range : 270-340   170-240   140-170   100-130   70-90
(Amps)
Qty.(Pcs./Carton) : 25   35   55   75   125

APPROVAL: BHEL

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