Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

MOLYTHERME(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^{0}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) Dia x Length	:	6.3x450	5x450	4x350	3.15x350	2.5x350
Current Range (Amps)	:	270-340	170-240	140-170	100-130	70-90
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.