MOLYTHERME-MOD

CODIFICATION:
AWS : SFA 5.5 E7018-A1
IS : 1395 E49 B A1 2 6 Fe

CHARACTERISTICS AND APPLICATIONS:
Low hydrogen iron powder electrodes depositing 0.5%Mo with excellent toughness. Weld metal retains mechanical properties after prolonged heat treatments. Ideal for welding C-0.5 Mo steels, plates, pipes for pressure vessel, boilers, etc. where toughness at -20°C is required. The weld metal possesses good creep strength up to 525°C.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element: C Mn Si S P Mo
Percent: 0.06 0.85 0.42 0.015 0.02 0.5

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT: 620°C FOR 1 HR)

<table>
<thead>
<tr>
<th>UTS (MPa)</th>
<th>YS (MPa)</th>
<th>Elongation (L = 4d)%</th>
<th>CVN Impact Strength at minus 20°C (Joules)</th>
</tr>
</thead>
<tbody>
<tr>
<td>525</td>
<td>465</td>
<td>27.0</td>
<td>75</td>
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</tbody>
</table>

CURRENT AND PACKING DATA: DC(+)

<table>
<thead>
<tr>
<th>Size (mm)</th>
<th>Dia x Length</th>
<th>Current Range (Amps)</th>
<th>Qty.(Pcs./Carton)</th>
</tr>
</thead>
<tbody>
<tr>
<td>6.3x450</td>
<td>5x450 4x450 4x350 3.15x350 2.5x350</td>
<td>270-320 200-250 140-170 140-180 100-130 70-90</td>
<td>25 30 50 50 75 100</td>
</tr>
</tbody>
</table>

PRECAUTIONS:
1. Rebake the electrodes at 250-300°C for one hour as per our standard recommended practice.
2. Use short arc and stringer bead.