MOLYThERME-SPL

CODIFICATION:  AWS: SFA 5.5 E9018-D1
              IS: 1395 E63BD126

CHARACTERISTICS AND APPLICATIONS:
Extra low hydrogen type electrodes depositing a high strength weld metal. The
electrode possesses excellent operating characteristics and is suitable for welding
in all positions. Weld metal has got good toughness even at subzero temperatures.
Deposition efficiency is about 115%. The weld metal possesses high strength
together with good notch toughness even at subzero temperatures down to minus
50°C. Ideally suited for welding fine-grained steels, high strength steels, IS: 8500-

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element:  C  Mn  Si  Mo  S  P  Ni
Percent:  0.06 1.45 0.50 0.40 0.020 0.021 0.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT: 620°C FOR ONE HR)
UTS (MPa)  YS (MPa)  Elongation (L= 5d)%  RA%  CVN Impact Strength (J) at
640  550  23.0  65.0  50  120  Minus 50°C  Minus 20°C

DIFFUSIBLE HYDROGEN CONTENT: 5 ml/100 gms of weld metal max.

CURRENT AND PACKING DATA: DC(+)
Size (mm):  5x450  4x450  3.15x450  2.5x350
Dia x Length
Current Range:  200-250  140-190  100-140  80-100
(Amps)
Qty.(Pcs./Carton):  35  55  75  125

APPROVALS: RD & SO Class-C1

PRECAUTIONS:
1. During welding keep the heat input to a minimum.
2. Ensure the electrodes are dry. Rebake electrode at 300°C for one hour
   before use.