MOLYTHERME

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

CHARACTERISTICS AND APPLICATIONS:
A low hydrogen iron powder type electrode yielding a weld deposit containing 0.5% Mo. Ideal for welding creep resistant C-Mo steels for service temperatures up to 525°C. Typical applications include boilers, pressure vessels, pipes and tubes of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:
Element : C  Mn  Si  Mo  S  P
Percent : 0.06 0.85 0.42 0.52 0.025 0.025

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:
(PWHT : 620°C FOR 1 HR)
UTS  YS  Elongation  CVN Impact Strength Creep Strength at
(MPa)  (MPa)  (L= 4d)%  at 27°C (Joules)  525°C (1% offset in 10,000hrs) kgf/mm²

535  455  28.0  140  12.5

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 90-120 70-90
(Amps)
Qty.(Pcs./Carton) : 25 35 55 75 125

APPROVALS: Adani Infra, BHEL, CIB-MP, EIL, NPCIL, NTPC, PDIL

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