

SUPRATHERME - Ni

CODIFICATION :

AWS	:	SFA 5.5 E7018-G
IS	:	1395 E49 B G 1 2 6 Fe

CHARACTERISTICS AND APPLICATIONS :

A low hydrogen, iron powder type electrode yielding a 0.5% Ni in the weld metal. Ideally suited for welding fine-grained steels, heavy sections, and restrained joints requiring good impact strength at sub-zero temperatures down to minus 50°C.

Typical applications include welding of C-Mn grain refined steels, heavy sections, and restrained joints requiring good impact strength at sub-zero temperatures down to minus 50°C.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Ni	S	P
Percent	:	0.06	1.0	0.30	0.55	0.018	0.018

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L= 4d)%	at minus 50°C (Joules)
525	446	28.0	45

CURRENT AND PACKING DATA : DC(+)

Size (mm)	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length						
Current Range	:	270-350	200-280	160-190	110-135	80-100
(Amps)						
Qty.(Pcs./Carton)	:	25	35	55	75	125

PRECAUTIONS :

1. Redry the electrodes as per our standard recommended practice.
2. Prevent excessive heat input during welding.