



SUPRATHERME-Ni (SPL)

CODIFICATION : AWS : SFA 5.5 E8018-G

CHARACTERISTICS AND APPLICATIONS :

A basic coated, low hydrogen, iron powder type electrode yielding a weld metal containing 1.5% Mn and 0.7% Ni. Excellent quality welds for welding heavy sections of fine-grained high strength steels with particular reference to low temperature service down to minus 60°C. Typical applications include welding of fine grained Q&T steels for pressure vessels, tanks, penstocks, where high strength and sub-zero temperature toughness properties are of importance.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Ni	S	P
Percent :	0.07	1.50	0.30	0.65	0.018	0.018

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at minus 50°C (Joules)
564	515	27.0	40

CURRENT AND PACKING DATA: DC(+)

Size(mm)	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length						
Current Range (Amps)	:	270-330	220-280	160-190	110-135	80-100
Qty.(Pcs./Carton)	:	25	35	55	75	125

APPROVALS: EIL, PDIL

PRECAUTIONS:

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