Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

SUPRATHERME-Ni (SPL) MOD

CODIFICATION: AWS : SFA 5.5 E8018-G

CHARACTERISTICS AND APPLICATIONS :

It is basic coated, low hydrogen, iron powder type electrode yielding a 1.0% Ni in the weld metal. Radiographic quality welds having excellent cracking resistance. Weld metal of excellent toughness to withstand heavy dynamic loading and impact. Ideally suited for welding fine grained steels, low alloy steels subjected to sub-zero temperature applications down to minus 60°C. Ideal for welding, heavy sections, highly restrained joints subjected to dynamic loading. Ideal for pressure vessels, tanks, spheres, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	C	Mn	Si	P	S	Ni
Percent	0.07	1.50	0.30	0.010	0.010	1.00

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact strength at minus 60°C (Joules)
570	520	27.0	75

CTOD (SENB) at 0°C : 0.25 mm minimum

CURRENT AND PACKING DATA : AC/DC(+)

Size (mm) Dia x Length	:	6.3 x 450	5 x 450	4 x 450	3.15 x 350	2.5 x 350
Current Range (Amps)	:	270-330	220-280	160-190	100-140	70-100
Qty.(Pcs./Carton)	:	25	35	55	75	125

PRECAUTIONS :

1. Re-dry the electrodes at 250-300°C for one hour.
2. For best impact properties, accomplish minimum heat input by: Using smallest size of electrode possible, minimum weaving, maximum number of layers, welding in down hand position wherever possible.