

# RATNA 7018 M

## Low Alloy Electrodes for Low Temperature services

**CLASSIFICATION** : AWS/SFA-5.5: E 7018 A1  
IS-1395: E 49BA 126Fe

**APPROVAL** :

**CHARACTERISTICS** : An iron powder, hydrogen controlled medium heavy coated electrode producing 0.50% Mo weld deposit. Electrode has high welding efficiency coupled with creep resistance properties at 525°C temperature and has excellent mechanical properties.

**APPLICATION** :

- 1) Suitable for high pressure boiler tubes and plates.
- 2) Fabrication for welding 0.50% Mo and 1% Cr-0.5% Mo steels used for elevated temperature services up to 525°C.
- 3) suitable for fine grained and creep resistant steel welding.

**RE-DRY CONDITION** : Re-Dry the electrode at 250°C-300°C for one hour, for best results.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Mo
0.12 max.	0.90 Max	0.60 Max	0.030 Max	0.030 Max	0.40-0.65

### ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
390 Min	490 Min	22 Min	+27 <sup>0</sup> C : 140 J (Min.)

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 70V)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	70-100	170	640
3.15/ 3.20 X 450	1/ 8" X 18"	100-130	110	440
4.00 X 450	5/ 32" X 18"	140-180	72	288
5.00 X 450	3/ 16" X 18"	190-230	50	200

Customer packing on request.