

## RATNA 7018Sp1

**Hydrogen controlled, Basic coated , Iron powder type electrode for outstanding toughness Impact properties.**

**CLASSIFICATION** : AWS/SFA-5.1: E 7018-1, BS 639 E 5122RR21032  
IS-814: EB 5426 H3JX, DIN 1913 E 5122RR1135200

**APPROVAL** : BV, BAX, PDIL

**CHARACTERISTICS** : An iron powder, hydrogen controlled electrode producing tough & ductile weld metal for welding heavy & rigid structure subjected to dynamic loading. The weld metal is of radiographic quality and displays remarkable mechanical properties like toughness resistance even at -50°C temperature.

**APPLICATION** :

- 1) Suitable for high pressure boilers vessels.
- 2) Carbon steel rigid and heavy structures.
- 3) Steels sensitive to hydrogen embrittlement and prone to crack.
- 4) Industrial equipment subjected to severe impact.
- 5) off-shore drilling rigs and flat forms
- 6) Equipments require heavy impact at minus 46°C.
- 7) Thick plate of carbon steels.

**RE-DRY CONDITION** : Re-Dry the electrode at 250°C-300°C for one hour before use.

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.10 max.	1.00-1.60	0.50 Max	0.030 Max	0.030 Max

### ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
460-520	520-620	24-32	-46°C : 50-80 J

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 90V)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	80-100	170	640
3.15/ 3.20 X 450	1/ 8" X 18"	110-140	110	440
4.00 X 450	5/ 32" X 18"	150-180	72	288
5.00 X 450	3/ 16" X 18"	210-260	50	200
6.30 X 450	15/ 64" X 18"	240-320	32	128

Customer packing on request.