

RATNA 7018W

Hydrogen controlled low alloy steel electrode designed for welding of weathering steels.

CLASSIFICATION : AWS/SFA-5.5: E 7018-W1 H4
UNS No. W20018

APPROVAL :

CHARACTERISTICS : A Hydrogen controlled basic coated electrode for welding weathering steels. Weld metal relatively high resistance to atmospheric corrosion. Very low level of diffusible hydrogen in welds. Weld metal gives radiographic quality.

APPLICATION :

- 1) Suitable for welding of weathering steels like SAILCOR-A & CORTEN A & B steels & equivalent.
- 2) Medium tensile corrosion resistant structure steels and welding of high tensile steels.
- 3) Electrode suitable for typical weathering steels, such as ASTM A 242 and A 588

RE-DRY CONDITION : Re-Dry the electrode at 350°C for 1 hrs before use.

HYDROGEN CONTENT: 4.00ml/100grams Weld metal

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Cu	V
0.12 max.	0.40-0.70	0.40-0.70	0.15-0.30	0.20-0.40	0.30-0.60	0.08 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4xd)	CHARPY "V" NOTCH IMPACT AT
415 min.	490 min.	22 min.	-20°C : 50-80 J

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	3/ 32"	70-100	170	640
3.15/ 3.20	1/ 8"	100-140	110	440
4.00	5/ 32"	150-190	72	288
5.00	3/ 16"	200-250	50	200

Customer packing on request.