RATNA-8018 C1

A Basic coated 2.50% Ni alloyed electrode for welding low ally steels.

CLASSIFICATION : AWS/SFA-5.5: E 8018 C1
IS-1395: E 55BC 126Fe

APPROVAL :

CHARACTERISTICS : A medium coated Hydrogen controlled, basic coated iron powder type electrode presence of Mn & Ni in appropriate proportion imparts to weld a high degree of low temperature notch toughness. The weld deposit controlled 2.50% Ni which imparts good resistance to brittle fracture down to -59°C.

APPLICATION :

1) Suitable for fabrication of LNG storage tanks.
2) Liquified gases, cryogenic vessels, to weld 2.25% Ni steels, oil refinery valves, pressure vessels.
3) Construction of components to be subjected to low temperature service in petrochemical industries.

RE-DRY CONDITION : Re-Dry the electrode at 300°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	S& P
0.12 max.	0.80-1.25	0.60 max	2.00-2.75	0.025 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm^2)	UTS (N/mm^2)	EL % (l=4xd)	CHARPY "V" NOTCH IMPACT AT
460-560	550-650	22-28	-60^0C : 50-100 Jouls

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 14"/ 18"	100-130	110	440
4.00 X 450	5/ 32" X 18"	150-180	72	288
5.00 X 450	3/ 16" X 18"	190-230	50	200

Customer packing on request.