

RATNA 8018 P2

Specifically designed for high strength API 5L pipe welding.

CLASSIFICATION : AWS/SFA-5.5: E 8018 P2

APPROVAL :

CHARACTERISTICS : Low hydrogen type, moisture resistant electrode have specifically been designed for the welding of fill and cap passes in high strength pipe butt joints using vertical downward and upward progression. These electrode not recommended for the root pass (stringer bead) on open gaps.

APPLICATION :

1. Welding of high strength API 5L pipe steels.
2. Welding suitable for other high strength, medium and high carbon and low alloy steels.
3. Hot tapping and Pipe repairing

RE-DRY CONDITION : Electrode re-dry @ 350°C for 1 hrs.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S&P	Ni	Cr	Mo	V
0.12 max.	0.90-1.70	0.80 Max.	0.030 Max	1.00 Max.	0.20 Max	0.50 Max.	0.050 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
460 Min.	550 min.	19 min.	Minus 30 ⁰ C : 80 J Min.

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+) Amps	Kgs/pkt.	Kgs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	90-120	5	20
3.15/ 3.20 X 350	1/ 8" X 14"	120-170	5	20
4.00 X 350	5/ 32" X 14"	170-230	5	20

Customer packing on request.