

# RATNA-8018 W

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

**CLASSIFICATION** : AWS/SFA-5.5: E 8018 W2  
IS-1395: E 55BG 126Fe

**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.

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

## ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Cu
0.12 max.	0.80-1.30	0.35-0.80	0.40-0.70	0.40-0.80	0.30-0.75

## ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4xd)	CHARPY "V" NOTCH IMPACT AT
460-560	550-670	22-28	-20 <sup>0</sup> 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 X 350	3/ 32" X 14"	70-100	170	640
3.15/ 3.20 X 450	1/ 8" X 14"/ 18"	100-140	110	440
4.00 X 450	5/ 32" X 18"	150-190	72	288
5.00 X 450	3/ 16" X 18"	200-250	50	200

Customer packing on request.