

## LOW HYDROGEN IRON POWDER ELECTRODE FOR 2.5% NICKEL STEELS

EURO CRAFT – C1

### CODING:

AWS: E 8018 C1

### CHARACTERISTICS:

EURO CRAFT C1 is a heavy coated low hydrogen iron powder type electrode specially meant for welding 2.5% nickel steels and suitable for service temp upto -75°C. The electrode operates well on AC as well as DC+ in all welding positions.

### USES:

EURO CRAFT C1 can be used for welding 2.5% nickel steels, high tensile alloys steels, boilers, pressure vessels, pipelines for liquid gases, storage tanks etc and steels of grades A 203, A33, A 350, A 515, & A 516 etc.

### NOTED FEATURES:

1. The electrode is easy to operate on AC as well as DC+.
2. Sound and ductile weld metal with radiographic qualities.
3. Easily detachable slag, shining and fine rippled bead.
4. Good impact properties upto minus 75°C.

### CURRENT CONDITIONS:

| SIZE mm      |           | 2.50 X 350 | 3.15 X 350 | 4.00 X 350 | 5.00 X 350 |
|--------------|-----------|------------|------------|------------|------------|
| CURRENT-Amps | DC+/AC 70 | 60-100     | 100-140    | 140-190    | 200-260    |

### CHEMICAL ANALYSIS OF THE WELD METAL:

| Element | C       | Mn      | Si      | Ni       | S       | P       |
|---------|---------|---------|---------|----------|---------|---------|
| %       | 0.12max | 1.25max | 0.80max | 2.0-2.75 | 0.03max | 0.03max |

### MECHANICAL PROPERTIES OF THE WELD METAL:

1. Ultimate Tensile Strength(N/mm<sup>2</sup>) : 610-630
2. 0.2% Proof Stress (N/mm<sup>2</sup>) : 550-570
3. Elongation(%) on 50mm gauge length : 22-24
4. Impact Strength(J)@ 27°C : 130-150

### SPECIAL INSTRUCTIONS:

1. Electrodes should be totally free from moisture before use.
2. Rebake electrodes @ 350°C for one hour before use. Cool to 100°C and then maintain @ 100°C before use.
3. Use smaller gauge electrodes to avoid excess heat.
4. Maintain interpass temp. of about 150°C.
5. Slow cooling is advisable