

## LOW HYDROGEN IRON POWDER ELECTRODE FOR NICKEL STEELS

EURO CRAFT C3

### CODING:

AWS: E 8018 – C3

### CHARACTERISTICS:

**EURO CRAFT C3** is a heavy coated low hydrogen iron powder type electrode specially designed for service temp upto minus 60°C. It operates equally well on AC as well as DC(+) in all welding positions. The weld metal is tough and ductile and contains 1% nickel. The electrode is well suited for welding nickel steels and storage tanks for liquid gases where the temp requirement is upto minus 60°C.

### NOTED FEATURES:

1. Smooth and stable arc with easy striking and restriking characteristics.
2. Low spatter, easily detachable slag and fine rippled, defect free bead.
3. The weld deposit is tough, ductile and is of radiographic quality.
4. The electrode is well suited for welding 1% nickel steels and for service temp. upto minus 60°C.

### USES:

**EURO CRAFT C3** can be used for welding 1% nickel steels, high tensile alloy steels, boilers, pressure vessels, pipe lines and storage tanks for liquid gases where the temp. requirement is upto minus 60°C, steels of grades A 148, A 225, A 236, A243, A 290, A 294, A 300etc.

### RECOMMENDED CURRENT RANGES AND PACKING DETAILS:

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

### TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	Ni	S	P
percent	0.12max	0.40 - 1.25	0.80max	0.80 – 1.10	0.03max	0.03max

### TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

UTS N/sq mm	% Elongation	CVN Impact value
610-630	26-28	140-150(at +27°C) 50 - 70(at -40°C) 30 - 50 (at -60°C)

### SPECIAL INSTRUCTIONS:

1. Electrodes should be absolutely dry before use.
2. Rebake electrodes at 350°C for one hour. Cool to 100°C and then maintain at 100°C temp before use.
3. Use smaller gauge electrode to avoid excess heat and cracking of heat affected zone(HAZ).
4. Slow and uniform cooling is recommended.