

CLASSIFICATIONS:

AWS A/SFA 5.5 E 8018-G
BS E611JH
IS814 E55BG129Fe

CHARACTERISTICS:

A medium heavy coated, hydrogen controlled, iron powder type electrode specially developed for high tensile fine grained steels. The electrode gives a very smooth arc, medium penetration and low spatter characterised by easy operation in all position. The welds are of radiographic quality.

TYPICAL APPLICATIONS:

- Low alloy steels such as Si-Mn steels and steels containing Ni upto 1.0%.
- For welding high tensile steels for heavy construction work, subject to dynamic loading.
- For medium tensile steels like BH39, BH47, BHW27, BHW30, Aldur 45/60 etc.

TYPICAL ALL WELD METAL CHEMICAL COMPOSITION:

Element	C	Mn	Si	Ni	S	P
%	0.05-0.10	1.40-1.85	0.20-0.48	0.45-0.80	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES

N/mm²

UTS	560-650
YS	460-570
Elongation(%)(l=4xd)	24-29
Reduction in area	50-80
CVN Impact Value 27±2 (°C)	120-200J

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT-Amps	AC/DC(+)	60-90	90-140	140-180	180-250