

**LOW HYDROGEN IRON POWDER ELECTRODE
FOR HIGH TENSILE STEELS**

EURO JET G

CODING:

AWS:SFA:5.5 E 9018-G

CHARACTERISTICS:

EURO JET G is characterized by smooth and stable arc which is easy to strike and restrike, low spatter, Easy deslagging, smooth and regular weld beads and high strength, tough weld deposits.

APPLICATIONS:

EURO JET G is ideally suited for

1. welding high tensile steels with UTS upto 70Kg/cm²
2. Welding grain refined, Q & T steels.
3. Fabrication of penstocks, tanks, pressure vessels etc.,

CHEMICAL & MECHANICAL PROPERTIES OF UNDILUTED WELD METAL:

Element	C	Mn	Si	Ni	Mo	S	P
%	0.08	1.0-1.4	0.2-0.6	1.0-1.6	0.25-0.6	0.03	0.03
Typical Element	0.065	1.20	0.40	1.40	0.50	0.025	0.025

	Y.S. Kg/mm ²	UTS Kg/mm ²	% Elongation	CVN Impact value @ 50°C(Kgfm)
Range	55.0min	64.0min	17min	2.8
Typical	59.0	68.0	22	4.0

CURRENT: DC(+)/AC90

Electrode Size	2.50x350	3.15x350	4.00x350	5.00x350
Current(Amps)	80-100	100-140	140-180	200-250

PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick up redry the electrodes at 300°C for one hour.
2. When welding grain refined and Q & T steels control the heat input by using stringer bead, control over preheat and inter pass temp. & short arc.