LOW HYDROGEN IRON POWDER ELECTRODE
FOR HIGH TENSILE STEELS

EURO JET M

CODING:
AWS- E 9018-M-H4
DIN 8529 EY55 76 Mn 1NiMo B H5

CHARACTERISTICS:
EURO JET is a heavy coated low hydrogen iron powder type electrode especially designed for welding low alloy high tensile strength of 90,000 psi and above,high tensile nickel steels, molybdenum steels, heat and creep resistant steels and also suitable for service temperatures as high as 500ºC. The electrode is easy to operate on AC as well as DC(+) in all welding positions.

NOTED FEATURES:
- The electrode burns with low spatter, smooth and stable arc with easy striking and restriking.
- Easily removable slag and finer rippled bead.
- Tough and ductile weld metal which is of radiographic quality.
- Specially designed to suit high tensile steels, nickel steels as well as creep and heat resisting steels.

USES:
EURO JET is well suited for welding high tensile low alloy steels, nickel steels, nickel molybdenum steels, fillet and attachment welds in T-1, HY-80, HY-90 steels, quenched and tempered steels, boilers, pressure vessels, storage tanks for liquefied gases, pipelines etc.

RECOMMENDED CURRENT RANGES:

SIZE mm	2.5 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT- Amps	60-100	100-140	140-190	200-260

CHEMICAL ANALYSIS OF THE WELD METAL :

Element	C	Mn	Si	Ni	Mo	S	P
%	0.07	1.10	0.40	1.70	0.30	0.03	0.03

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/mm^2	UTS N/mm^2	% Elongation	CVN Impact value (J)
580-620	670-690	25-27	100(at + 27°C) 55(at - 50°C)

SPECIAL INSTRUCTIONS:
- Do not use electrode directly from the packet.
- Rebake electrodes @ 350ºC for one hour. Cool to 100ºC and maintain @ 100ºC before use.
- Use small gauge electrodes to avoid excess heat and to avoid cracking.
- Minimum and slow weaving motion should be carried out alternatively stringer bead technique is recommended. Slow cooling after welding is advisable.