

EURO ULTRA D2**CLASSIFICATIONS:**

AWS A/SFA 5.5 E 10018 D2
IS 814 E 68 BD 229Fe

CHARACTERISTICS:

A low alloy, high tensile hydrogen controlled all position electrode suitable for joining fully killed fine grained steels. Very little spatter easily removable slag. The welds are of radiographic quality with uniform ripples. The electrode should be redried at 300°C for 2Hrs to obtain best results.

TYPICAL APPLICATIONS:

- For welding low-alloy, high strength fully killed fine grained steels having a tensile strength of about 70Kgf/mm² penstocks.
- Earthmoving equipment etc.,

TYPICAL ALL WELD METAL CHEMICAL COMPOSITION:

Element	C	Mn	Si	Ni	Mo	S	P
%	0.15max	1.65-2.00	0.20-0.60	0.90max	0.25-0.45	0.03 max	0.03max

ALL WELD MECHANICAL PROPERTIES**N/mm²**

UTS	690-790
YS	600-700
Elongation(%)(l=4xd)	16-24
CVN Impact Value -51°C	30-70J

CURRENT CONDITIONS:

SIZE mm	2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT- Amps	AC/DC(+) 50-90	90-140	140-180	180-250