

**CODING:**

AWS E 7018 G

**EUTHERME LH G****CHARACTERISTICS AND APPLICATIONS:**

A low hydrogen, iron powder type electrode yielding a 0.5% Ni in the weld metal. Ideally suited for welding fine grained steels, heavy sections, restrained joints requiring good impact strength at subzero temp down to minus 50°C .

Typical applications include welding of C-Mn grain refined steels, heavy sections, restrained joints requiring good impact strength at sub-zero temp down to minus 50°C .

**TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:**

C	Mn	Si	Ni
0.06	1.0	0.30	0.60

**TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:**

UTS (Kg/mm <sup>2</sup> )	YS (Kg/mm <sup>2</sup> )	Elongation (L=4D)%	CVN Impact Strength -50°C (J)
53.0	45.0	28.0	45

**CURRENT CONDITIONS**

SIZE mm	2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT -Amps	80-100	110-135	160-190	220-280

**PRECAUTIONS:**

1. Redry the electrodes as per our standard recommended practice.
2. Prevent excessive heat input during welding.