

ROYAL THERM SPL H4R (E 7018-1 H4 R)

AWS : SFA 5.1, E 7018-1 H4 R

Applications

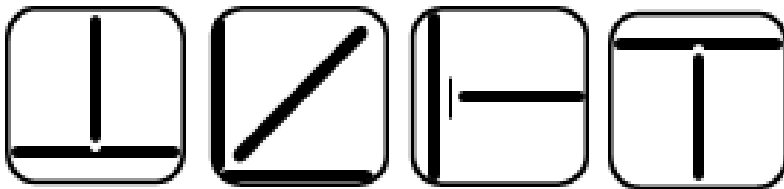
All maintenance application including welding of all types of Carbon-manganese steel, high tensile steel, heavy structure, plant and equipments subject to static or dynamic loading. Can be used as a buffer layer before hardfacing.

Characteristics on Usage

hydrogen controlled, vacuum packed, basic coated electrodes which is welder friendly and is recommended for welding of mild steel, medium carbon, steel, high strength steel, cast steel and problematic steels. The electrodes is vacuum packed and hence does not require expensive redrying at 250oC for 2 hours or a higher temperature. The weld metal is clean and has lowest level of impurities with has much longer life than the weld metal usually deposited with other E 7016 or E 7018 class of electrodes. Deposited weld metal met X-ray radiographic quality standards. The

Notes On Usage

- 1) Dry the electrode a 300-350 °C for 60 Min- before use .
- 2) Keep the arc as short as possible.
- 3) Use wind screen against strong wind.

Welding Positions

1G

2F

3G

4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	Hydrogen content
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT - 45° C (J)	in 100 gm weld metal
490 Min	400 Min	22 % Min	27 Joules Min	4 ml Max

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	70-90
3.15 x 450	5	20		100-130
4.00 x 450	5	20		140-190
5.00 x 450	5	20		190-240

Packing

Vaccum packing