ROYAL – 8018 W (E 8018 W2)

AWS : A/SFA 5.5, E 8018 W2

Applications

Ideal for welding high tensile steel. Specially recommended for weathering steel like CORTEN A and B and their equivalents used in Chemical, Petrochemical, Railway, Industries to resist atmospheric corrosion.

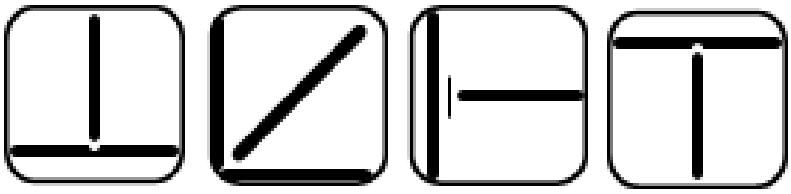
Characteristics on Usage

It is basic coated hydrogen controlled low alloy high tensile type electrode gives weld deposit of approx 0.6% Cr, 0.70% Ni and 0.50% Cu. which is highly resistance of atmospheric Corrosion. It gives a smooth arc medium penetration with easily removable slag. Easy to operate in all positions. Redry electrode at 250°C 2 hour for better results.

Notes On Usage

- 1) Dry the electrode a 250-350 °C for 60 Min- before use .
- 2) Keep the arc as short as possble.

Welding Positions



1G 2F 3G 4G

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Cu
0.12 Max	0.50-1.30	0.35-0.80	0.030 Max	0.030 Max	0.45-0.70	0.40-0.80	0.30-

Mechanical Properties Of Weld Metal

U.T.S. (N/mm²)	Y.S. (N/mm²)	ELONGATION (L = 4d) %	Weld deposit Hardness as welded condition	Diffusible Hydrogen contain in 100-grm weld metal deposit	CVN IMPACT AT - 20°C (J)
550 Min	460 Min	19 % Min	190 – 200 HV	5 ml Max	47 Joules Min

Approvals

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	60 – 90
3.15 x 450	100	400		100 – 140
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 250
6.30 x 450	30	120		250 - 300