

ROYAL THERM – (SPL) (E 7018 -1)

AWS : SFA 5.1 E 7018 – 1

IS : 814 EB 5629 H3JX

Applications

Boilers, Pumps & Compressors, Blast Furnace steel work, Bridges, Rail wagons, Earth Moving Equipment's, Road Building Machinery, Tanks, Pressure Vessels, Penstocks, Atomic Reactor Shell.

Characteristics on Usage

This unique electrode is capable of yielding welds which are of Radiographic quality specially designed for high Impact values down to – 46 centigrade and is crack resistant. This electrode has easy slag removal, excellent

Notes On Usage

- 1) Dry the electrode at 350-400 °C for 60 Min- before use .
- 2) Keep the arc as short as possible and avoid large width of weaving.
- 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose to prevent blow hole at the arc starting.

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	47 Joules Min	5 ml Max

Approvals

L.R.S., B.V., P.D.I.L., E.I.L., ABS, NPCIL, I.B.R., DNV, MRPL, BHEL, APG I L, IOCL, L&T, TPL UDHE INDIA LTD,

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	200	800	AC / DC (+)	80 – 100
3.15 x 450	100	400		100 – 135
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 250
6.30 x 450	30	120		250 – 320