



MODI 120

HIGH TENSILE STEEL ELECTRODE

CLASSIFICATION : AWS/A 5.5 : E 12018-G

CHARACTERISTICS : A basic coated, low hydrogen, low alloy, very high tensile steel electrode. Weld metal displays high strength and toughness. Electrode works in all positions and gives radiographic quality welds. Metal recovery is over 100%.

APPLICATIONS : Electrode is designed for welding high strength steels, joining/surfacing Cr-Ni-Mo-alloyed steels, heat treatable steels and case hardening steels.

RECOMMENDATIONS : Re-dry the electrodes at 350°C for 1 hour or at 250°C for 2 hours. Keep the re-dried electrodes in a holding oven at 125°C-150°C. Maintain interpass temperature below 110°C. Preheat and post heat treatment recommended by steel manufacturer should be strictly followed. Prevent excessive heat input.

CHEMICAL ANALYSIS OF WELD METAL (%)

	C	Mn	Si	Cr	Ni	Mo	S	P
	0.070	1.0	0.34	1.1	2.2	1.0	0.025	0.024

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.5)

	Yield Strength	Ultimate Tensile Strength	Elongation (%)	CVN Impact Values at 0°C (Min)
	N/mm ²	N/mm ²	(%)	(Min)
	843	956	19	58

CURRENT CONDITIONS : USE AC(90V) or DC (+)

Size (mm)	2.5x350	3.15x350 3.15x450	4.0x450	5.0x450	6.3x450
Range (Amps.)	70-100	100-130	140-180	190-240	240-280



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