



MODI - 7018 (NACE)

LOW HYDROGEN, LOW SULPHUR ELECTRODE

CLASSIFICATION :

IS : 814-2004 : EB 5426 H₃JX
AWS/A 5.1 : E 7018 H₄

CHARACTERISTICS :

A hydrogen controlled medium heavy coated iron powder electrode, suitable for welding of medium high tensile strength steels. The all position electrode, produces smooth and stable arc, easily detachable slag and least spatters. Metal recovery is minimum 110%. Welds are of consistent radiographic quality. Weld metal displays excellent mechanical properties and excellent resistance to cold and hot cracking.

SPECIAL FEATURES :

Apart from conforming to EIL Specification for Sour Services, GS 8 - Annexure I, Modi 7018 (NACE) meets the requirements of :

1. Sulphide stress Corrosion Cracking test as per NACE Standard TM-01-77.
2. Hydrogen Induced Cracking test as per NACE Standard TM-02-84.

APPLICATIONS :

- * Off-shore drilling rigs, pipes, platforms
- * Storage tanks
- * Pressure vessels.
- * Penstocks
- * Bridges
- * Blast furnace shells.
- * Pipelines.
- * Dynamic loaded structure.

RECOMMENDATIONS :

Re-dry the electrodes at 350°C for one hour or at 250°C for two hours. Keep the re-dried electrodes in a holding oven having 70-100°C temperature. Use the electrodes directly from holding oven. Use short arc and stringer bead technique to get optimum

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	S	P
0.09max	0.90-1.40	0.60max	0.012max	0.020max

MECHANICAL PROPERTIES OF ALL WELD-METAL :

Yield Strength	Ultimate Tensile Strength	Elongation (%)	Red. Area (%)	CVN Impact Values at -30°C	Hardness
N/mm ²	N/mm ²	(%)	(%)	Joules	RC
410-530	490-600	24 Min	60 Min	50 Min	22.0

CURRENT CONDITIONS : USE AC (70V) OR DC (+) ONLY

Size (mm)	2.5x350	3.15x450	4.0x450	5.0x450
Amps	70-100	100-140	140-180	180-240

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