



MODI - 7018

LOW HYDROGEN ELECTRODE

CLASSIFICATION :

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

APPROVALS :

BIS	CIB(UP)	BHEL
LRS	NPC	DNV
EIL	BVIS	NTPC
ABS	PDIL	LANCO
		TOYO

CHARACTERISTICS :

A low hydrogen iron powder electrode, suitable for welding of medium tensile strength steels. Weld metal is of radiographic quality. Deposition efficiency is minimum 110%. Medium tensile strength and excellent ductility combined with very good impact values at minus 30°C temperature makes the electrode versatile. Typical hydrogen content 5ml/100gms. of weld deposit.

APPLICATIONS :

- * Storage Tanks
- * Pressure Vessels
- * Penstocks
- * Boilers
- * Blast Furnace Shells
- * Railway Wagons
- * Pipe Lines
- * Dynamic Loaded Structures

RECOMMENDATIONS :

Re-dry the electrodes at 350°C for one hour. Keep the redried electrodes in a holding oven having 70°C to 100°C temperature. Use electrodes directly from holding oven. Use short arc to get optimum results. Stringer bead technique will ensure defect free weld deposits.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	S	P
0.10max	1.0-1.4	0.6 max	0.03max	0.03max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER IS:814-2004) :

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d) (%)	Reduction in Area (%)	CVN Impact Values at 27°C/-30°C
Kg/mm ²	Kg/mm ²			Joules
46-52	55-66	26 min	60 min	90/30
N/mm ²	N/mm ²			Kgf.m.
450-510	540-650			9/3

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

Size (mm)	2.5x350	3.15x450	4.0x450	5.0x450	6.3x450
Amps	70-100	100-140	140-180	180-240	240-300

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