



# MODI - 7018 A1

## HIGH STRENGTH ELECTRODE

**CLASSIFICATION :**

**IS : 1395-82 : E49 B-A1-26 Fe**  
**AWS/A 5.5 : E 7018 - A1**

**APPROVALS :**

CIB (UP), PDIL, NTPC, LANCO, BHEL

**CHARACTERISTICS :**

An outstanding hydrogen controlled electrode for welding of 0.5% Mo steels and other low alloy steels subjected to elevated temperature upto 525°C. Welds are of radiographic quality. Coating is especially formulated to resist moisture pick up under condition of high humidity. It has a good slag detachability and a high operator appeal. Metal recovery is minimum 110%.

**APPLICATIONS :**

- \* Boilers
- \* Pipes
- \* Elevated Temperature Service upto 525°C
- \* Pressure Vessels
- \* Tubes

**RECOMMENDATIONS :**

Use stringer bead technique and lower currents to ensure proper alloy transfer. Re-dry the electrodes at 350°C for one hour or 250°C for two hours. Maintain interpass temperature around 100°C.

**CHEMICAL ANALYSIS  
OF WELD-METAL(%) :**

C	Mn	Si	Mo	S	P
0.10 max	0.9 max	0.6 max	0.40-0.65	0.03	0.03

**MECHANICAL PROP-  
ERTIES OF ALL WELD-  
METAL (AS PER  
AWS/A 5.5) :**

Yield Strength	Ultimate Tensile Strength	Elongation
N/mm <sup>2</sup>	N/mm <sup>2</sup>	(%)
450-550	540-660	25 min

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

Size (mm)	2.5x350	3.15x450	4.0x450	5.0x450	6.3x450
Amps	70-100	100-140	140-180	190-240	250-300

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