



MODI 7018G

LOW HYDROGEN ELECTRODE

CLASSIFICATION :

IS : 1395-82 : E 49B-G126
AWS/A 5.5 : E 7018-G

CHARACTERISTICS :

A hydrogen controlled iron powder type electrode yielding 0.5% Ni in the weld metal. Electrode is specially designed for excellent notch toughness at sub zero temperature even when welded in vertical uphill progression. Electrode gives radiographic quality weld. Metal recovery is over 110%.

APPLICATIONS :

- * Low alloy steels such as Si-Mn steels.
- * Steels containing Nickel upto 1.0%
- * Heavy sections and restrained joints subjected to dynamic loading.

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. Keep the re-dried electrodes in holding oven having 120°C - 150°C temperature. Use the electrodes directly from the holding oven.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Ni	Si	S	P
0.10 max	1.4-1.7	0.50-0.75	0.30-0.50	0.03max	0.03max

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

Yield Strength	Ultimate Tensile Strength	Elongation (%)	CVN Impact Volume at -50°C
N/mm ² 480 min.	N/mm ² 550 min.	(%) 25min	Joules 50 min (Avg.)

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

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

**MODI ARC ELECTRODES CO.**

Modinagar - 201 204 (U.P.)

Fax : 01232 - 242147

Phone : (01232) 325700, 325925, 243912

E-mail : modiarc@ndb.vsnl.net.in

Web Site : www.modielectrodes.com