



MODI - 8018 C2

LOW HYDROGEN ELECTRODE

CLASSIFICATION :

IS : 1395-82 : E 55 B-C2-26 Fe
AWS/A 5.5 : E 8018 - C2

CHARACTERISTICS :

An excellent electrode designed for welding of fine grains steels and nickel steels having 3.0 to 3.75%. Nickel for service temperature down to minus 73°C. Coating is specially designed to resist moisture pick up.

The weld metal displays excellent strength & high notch toughness. Metal recovery is above 110%.

APPLICATIONS :

- * Valves & tanks for storage, transportation & distribution of liquified propane, Butane, Ethane, Acetylene
- * Welding of pressure vessels & Piping systems

RECOMMENDATIONS :

Re-dry the electrodes at 350°C for one hour or at 250°C for two hours. Keep the redried electrodes in a holding oven at 120°C-150°C. Use the electrodes directly from holding oven. Pre-heat and interpass temperature should be maintained between 95°C-120°C. Stress relieving temperature shall be done at 620°C±14°C for one hour followed by slow cooling.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Ni	S	P
0.10 max	1.25 max	0.8 max	3-3.75	0.03 max	0.03 max

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

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d)	CVN Impact Values at -73°C
N/mm ² 460 min	N/mm ² 550 min	(%) 22.0 min	Joules 30 min

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x450	4.0x450	5.0x450	6.3x450
Amps	70-110	100-140	140-180	180-220	230-280

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