



MODI - 9018

HIGH STRENGTH ELECTRODE

CLASSIFICATION :

IS : 1395-82 : E 63B-G129 Fe
AWS/A 5.5 : E 9018 G

CHARACTERISTICS :

A basic type, low hydrogen iron powder electrode for welding of high tensile grade steels. Easy to operate on AC or DC(+) in all conventional positions. Metal recovery is approx. 115%. Gives radiographic quality welds. Diffusible hydrogen in weld metal is around 5ml. per 100 gms. of weld metal.

APPLICATIONS :

- * High Tensile Steels upto 70 Kg/mm² UTS.
- * Earthmoving equipments, penstocks, Tanks and other similar heavy fabrications.

RECOMMENDATIONS :

Re-dry the electrodes at 350°C for one hour. Keep the redried electrodes in a holding oven at 120-150°C. Depending upon the composition, thickness and restraint of the joint, preheat the job between 100 to 150°C. Maintain interpass temperature 150°C max. Stress relieving temperature should be 620°C±14°C for one hour.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr
0.10 max	1.20-1.80	0.50 max	0.30max
Ni	Mo	S	P
0.6-1.0	0.30max	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 -51°C
N/mm ²	N/mm ²		Joules
550-650	650-720	18 min	30 min

CURRENT CONDITIONS : USE AC (90V) OR DC (+)

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

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