

SUNTHERM 11018 M

High Tensile Electrode



CLASSIFICATION

AWS/A 5.5 : E 11018 M

IS 1395-82 : E76B-M3 29Fe

CHARACTERISTICS

A low hydrogen iron powder electrode designed for welding of fine grained high tensile steels, hardened and tempered steels such as USS T-1 steels etc. Weld metal is of radiographic quality and gives uniform mechanical properties. Metal recovery is over 110%.

APPLICATIONS

Penstocks, Bridges, Earthmoving equipments, Parts of dressing plants, welding of USS T-1 and Welten steels, welding fine grained steels like HY 80, HY 90, HY 100.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus	Chromium	Molybdenum	Nickel
0.076	1.4	0.42	0.019	0.018	0.20	0.40	1.56

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d)	CVN Impact Values at minus 51°C
690.0 N/mm ²	782.0 N/mm ²	21.80%	38 Joules avg

CURRENT CONDITION & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC 70 V or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	70-100	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg

RECOMMENDATIONS:

Redry the electrodes at 350°C for one hour or at 250°C for two hours. Keep the redried electrodes in a holding oven having 60-80°C temperature. Use short arc to the extent possible.