FINE LH 18 (E 7018)

AWS : A 5.1, E 7018
IS : 814 EB 5426H3JX

APPLICATIONS :-

It is used for welding of high carbon steel to Mild Steel, High Carbon Steel Parts, Low Alloy Steel, Cast Steels as well as unknown composition of steel. Recommended for welding higher carbon & higher sulphur steel.

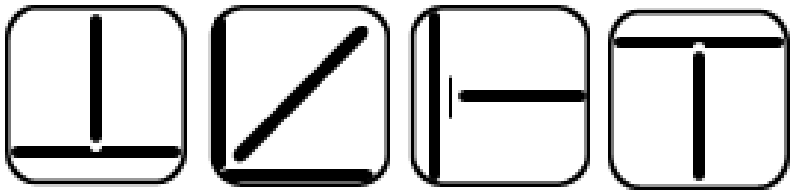
CHARACTERISTICS ON USAGE :-

It is medium coated, hydrogen controlled all position electrode. It gives a smooth clean weld deposit with least spatter due to having a special type of lime coating. The weld metal is highly resistant to cracking and gives radiographic quality. Dry the electrodes at 300 °C for hour for best result.

NOTES ON USAGE :-

1) Dry the electrode at 300-350 °C for 60 min.before use.
2) Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.
3) Use wind screen against strong wind

WELDING POSITIONS :-



1G 2F 3G 4G

CHEMICAL COMPOSITION OF WELD METAL

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.20 Max	0.30 Max	0.30

MECHANICAL PROPERTIES OF WELD METAL

U.T.S. (N/mm²)	Y.S. (N/mm²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)	RADIOGRPHY TEST	Hydrogen (Mercury Method) in 100grm weld metal
490 Min	400 Min	22 % Min	27 Joules Min	Satisfactory as per IIW blue std	5 ml (Max)

PACKING AND WELDING CURRENT

ITEMS	SIZE	PKT/BOX	PCS/PKT	PCS/BOX
FINE LH 18				
FINE LH 18	2.50 X 350 M.M.	4	150	600
FINE LH 18	3.15 X 450 M.M.	4	100	400
FINE LH 18	4.00 X 450 M.M.	4	70	280
FINE LH 18	5.00 X 450 M.M.	4	45	180
FINE LH 18	6.30 X 450 M.M.	4	30	120