

**FINE LH18(SPL) (E 7018 -1)**AWS : SFA 5.1 E 7018 – 1  
IS : 814 EB 5629 H3JX**APPLICATIONS :-**

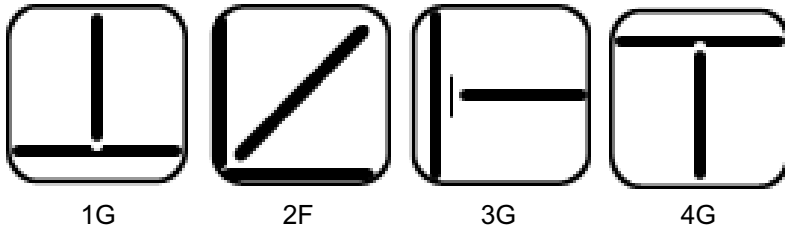
Boilers, Pumps & Compressors, Blast Furnace steel work, Bridges, Rail wagons, Earth Moving Equipment's, Road Building Machinery, Tanks, Pressure Vessels, Penstocks, Atomic Reactor Shell.

**CHARACTERISTICS ON USAGE :-**

This unique electrode is capable of yielding welds which are of Radiographic quality specially designed for high Impact values down to – 46 centigrade and is crack resistant. This electrode has easy slag removal, excellent

**NOTES ON USAGE :-**

- 1) Dry the electrode at 350-400 °C for 60 Min- before use .
- 2) Keep the arc as short as possible and avoid large width of weaving.
- 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose to prevent blow hole at the arc starting.

**WELDING POSITIONS :-****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/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT ( CVN ) AT - 45° C ( J )	Hydrogen Content in 100 gm Weld Metal
490 Min	400 Min	22 % Min	47 Joules Min	5 ml Max

**PACKING AND WELDING CURRENT**

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