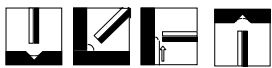


RD-18C	LOW HYDROGEN - IRON POWDER ELECTRODE FOR WELDING LOW ALLOY FERRITIC STEELS USED FOR SEMI-CRYOGENIC WORK				DATA SHEET NO. 34				
SPECIFICATION	AWS A5.5		BS EN ISO 2560-B						
CLASSIFICATION	E8018-C1		E5518-N5						
PRODUCT DESCRIPTION	<p>The design emphasis of the chemically basic flux is engineered to ensure the optimum weld metal properties demanded by the specification are fully met.</p> <p>The basic flux containing the appropriate alloying elements with a controlled balanced addition of iron powder, is extruded onto a high purity ferritic core wire with a blend of silicates that ensures both coating strength and a coating resistant to subsequent moisture absorption.</p>								
WELDING FEATURES OF THE ELECTRODE	<p>The chemical nature of the flux together with a significant proportion of iron powder ensures maximum deposition efficiency without detracting from its ability to be used in all positions except vertical down.</p> <p>Overall the arc is very stable, slag detachability is good and metal recovery is some 115% with respect to the core wire.</p>								
APPLICATIONS AND MATERIALS TO BE WELDED	<p>C-Mn and low alloy steel plate, pipe forgings and castings used extensively for service at cryogenic temperatures, eg: LT50. UNCONTROLLED</p> <p>BS 1501-224 Grade 490B Plate. ASTM A333 Grade 6 Pipe. ASTM A350 Grades LF1/LF2 Forgings. ASTM A352 Grade LC2 Castings.</p> <p>Maximum stress relief temperatures should be 620 °C (for 1 hour)</p>								
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Ni Fe		
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS				
WELDING AMPERAGE AC or DC+	Ø (mm)	2.6	3.2	4.0	5.0				
	MIN	70	110	140	180				
	MAX	100	150	190	220				
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.								
RELATED PRODUCTS	Please contact our Technical Department for detail.								