



This group of electrodes is suited for welding all thicknesses of steel, either wrought or cast, and even high carbon variants, provided the appropriate pre-heat and post-weld heat treatment is applied.

***These electrodes all have the following features in common :***

1. A moisture free chemically basic flux coating that is resistant to subsequent moisture reabsorption which ensures very low as opposed to low weld metal hydrogen levels\* and thus the absence of weld metal and HAZ hydrogen embrittlement.

(Note : very low hydrogen levels =  $H_2 < 5$  ml/100g; low hydrogen levels =  $H_2 < 10$  ml/100g)

2. Weld metal with low levels of oxygen and non-metallic inclusions which imparts great resistance to solidification cracking on exceptionally thick sections under great restraints. The higher the Mn-Si ratio, the greater the resistance to solidification cracking.

3. For the class of electrode they represent, exceptional sub-zero toughness values are obtained, eg: general purpose types assure toughness values to at least  $-30$  °C, the higher manganese alloyed types to at least  $-50$  °C and the nickel alloyed types to  $-80$  °C.

4. Both strength and toughness properties of the weld metal are maintained after most weld

stress relief heat treatments.

TYPE	AWS	DESCRIPTION	DATASHEET
RD-360	A5.1 E7016	General purpose.	<a href="#">Download</a>
RC-52	A5.1 E7016	General purpose.	<a href="#">Download</a>
RD-360U	A5.1 E7016	One-sided root runs.	<a href="#">Download</a>
RC-52U	A5.1 E7016	One-sided root runs.	<a href="#">Download</a>
RD-360-1	A5.1 E7016-1	Impacts down to -50 °C.	<a href="#">Download</a>
RD-718	A5.1 E7018	General purpose.	<a href="#">Download</a>
CR-718	A5.1 E7018	Impacts down to -50 °C.	<a href="#">Download</a>
RD-718-1	A5.1 E7018-1	Impacts down to -50 °C.	<a href="#">Download</a>
RD-51	A5.5 E8018-W2	Weather proof steels.	<a href="#">Download</a>
RD-716G	A5.5 E7016-G	Impacts down to -50 °C.	<a href="#">Download</a>
LN-15	A5.5 E8016-G	Impacts down to -60 °C.	<a href="#">Download</a>
RD-48	A5.1 E7048	Vertical down	<a href="#">Download</a>
RD-16C	A5.5 E8016-C1	Impacts down to -70 °C.	<a href="#">Download</a>
RD-16C2	A5.5 E8016-C2	Impacts down to -80 °C.	<a href="#">Download</a>
RD-80	A5.5 E8016-G	For cast high carbon steels	<a href="#">Download</a>
RD-18C	A5.5 E8018-C1	Impacts down to -70 °C.	<a href="#">Download</a>
RD-18C2	A5.5 E8018-C2	Impacts down to -80 °C.	<a href="#">Download</a>
RD-18G	A5.5 E8018-G	Impacts down to -60 °C. (NACE)	<a href="#">Download</a>
RD-718G	A5.5 E7018-G	Impacts down to -50 °C (NACE)	<a href="#">Download</a>
RD-90	A5.5 E9016-G	Steels with UTS 600N/mm <sup>2</sup>	<a href="#">Download</a>
RD-100	A5.5 E10016-G	Steels with UTS 700N/mm <sup>2</sup>	<a href="#">Download</a>
RD-19D1	A5.5 E9018-D1	Steels with UTS 600N/mm <sup>2</sup>	<a href="#">Download</a>
RD-100D2	A5.5 E10018-D2	Steels with UTS 700N/mm <sup>2</sup>	<a href="#">Download</a>
RD-110	A5.5 E11016-G	Steels with UTS 800N/mm <sup>2</sup>	<a href="#">Download</a>
RD-110M	A5.5 E11018-M	Steels with UTS 800N/mm <sup>2</sup>	<a href="#">Download</a>
RD-118G	A5.5 E11018-G	Steels with UTS 800N/mm <sup>2</sup>	<a href="#">Download</a>

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