H ZULFI E 8018-C2

شركة مصنع الزلفي لاسلاك اللحام المحدودة
Zulfi Welding Electrodes Factory Co. LTD

Brand Name & Classification

AWS/ASME SFA-5.5: E 8018-C1
DIN 8529: E SY 42 87 3 Ni B H5
EN 499: E 46 3Ni B 42 H5

Approvals Grade

Properties

Electrode for producing crack free and tough welded joints. Gives weld of X-ray quality. Weld metal gives good impact values up to –100^0 c. due to its high metallurgical purity and low hydrogen content. Well suited for positional welding.

Application

Fine grain structural steels: StE 420, StE 460, StE500, WStE 420
WStE 460, WStE 500
TStE 420, TStE 460, TStE 500
Cryogenic steels: acc DIN17 173/17 174; TT St35
TT St 35 V, 10Ni 14

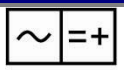
Weld Metal Analysis Typical values

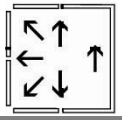
Carbon: 0.06
Silicon: 0.40
Manganese: 1.10
Nickel: 3.25

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
As Welded >490 N/MM^2 stress relieved 15 Hrs/ 580^0 c >420 N/MM^2	As welded >600 N/mm^2 stress relieved 15 Hrs at 580^0 c >550 N/MM^2	As welded >23 % stress relieved 15 Hrs/580^{0}c >20 %	As welded 180 J at +20^0 c 80 J at -60^0 c stress relieved 15 Hrs/580^0 c 200 J at +20^0 c 90 J at -60^0 c

Welding Current & Positions





Current

Dia	Length	Amperes
2.6	350	70-100
3.2	400	90-140
4.0	400	140-190
5.0	400	190-250