H ZULFI E 9018-G

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

Brand Name & Classification

AWS/ASME SFA-5.5: E 9018-G
DIN 8529: E SY50 76 Mn1NiMo BH5
EN 499: E 50 6 1Ni MoB 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 –60^0 c. due to its high metallurgical purity and low hydrogen content. Well suited for positional welding.

Application

Creep resistant steels: 13 MnNiMo 54, 17 MnMoV

Reactor steels: 20MnMoNi 55, 15 NiCuMoNb, 22 NiMoCr 37

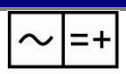
Weld Metal Analysis Typical values

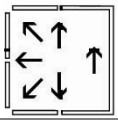
Carbon: 0.07
Silicon: 0.35
Manganese: 1.10
Nickel: 1.20
Molybdenum: 0.50

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
As welded >520 N/mm^2 stress relieved 15 Hrs/580^0 >520 N/MM^2	As welded >710 N/mm^2 stress relieved 15 Hrs at 580^0 c >680 N/MM^2	As welded >23 % stress relieved 15 Hrs/580^{0}c >20 %	As welded 150 J at +20^0 c 60 J at -50^0 c stress relieved 15 Hrs/580^0 c 150 J at +20^0 c 50 J at -50^0 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