

ZULFI E7018 H4R

CLASSIFICATION

AWS A5.1 E 7018 H4R
EN ISO 2560-A E 42 4 B 4 2 H 5

PROPERTIES

Electrode for producing crack free welded joints with good toughness properties even on steels having a carbon content up to 0.4%. Weld metal recovery is approximately 120%. Good operating characteristics even in positional welding. Weld metal exhibits good toughness properties down to -40 °C. Electrodes is suitable for depositing buffer layers on steels having a higher carbon content. Absorbed moisture content tested and it has passed up to 12 hrs.

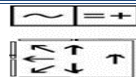
APPLICATIONS

Welding of storage tanks, pipes, pressure vessels, boilers, bridges, and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining steels like ASTM S-414M Gr C & D A414/SA. Gr 55 and Gr60 steels of S-516/516M.

CHEMICAL ANALYSIS [TYPICAL VALUES IN %]

C	Mn	Si	P	S	Ni	Mo
0.08	1.10	0.50	0.015	0.015	0.03	0.02

CURRENT CONDITION & WELDING POSITION



ALL-WELD METAL MECHANICAL PROPERTIES

HEAT TREATMENT	YIELD STRENGTH (MPa)	TENSILE STRENGTH (MPa)	ELONGATION %	IMPACT STRENGTH
As Welded	≥ 420	500 - 640	≥ 24	60J at -40 °C

PACKING DATA (NORMAL PACK)

DIAMETER (MM)	LENGTH (MM)	CURRENT (A)	WEIGHT PER PACKET (KG)	NO. OF PACKETS PER CARTON
2.0	300	50-80	3.5	6
2.6	350/400	70-100	2.5	8
3.2	400 / 450	90-140	5.0	4
4.0	400 / 450	140-190	5.0	4
5.0	400 / 450	190-250	5.0	4

Note: Also available in vacuum pack.