

LEADER MOLY THERM - SPL (E 8018 D3)

AWS : SFA 5.5, E 8018 D3

Applications

For welding 0.9% N & 0.5 Mo steel

Suitable for welding of manganese molly steel.

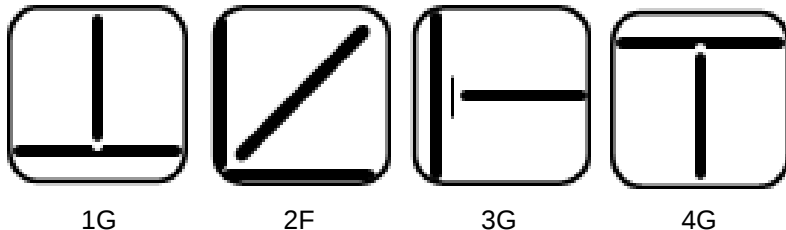
Low alloy high tensile boiler tubes & boiler Plates etc.

Characteristics on Usage

It is a medium heavy coated Hydrogen Controlled iron powder type all position electrodes deposit low alloy steel weld metal having 0.90% Ni & 0.50% Mo. Gives smooth arc, little spatter & easily removable slag. Specially suitable for the welding of Manganese molly steel and similar composition. The weld is of radiographic quality. Redry electrodes at 250 degree C for one hour for better result.

Notes On Usage

- ✍ 1) Dry the electrode at 350-400 °C for 60 Min- before use .
- ✍ 2) Preheat at 100 - 200 °C & post heat at 620 ± 15 °C
- ✍ 3) Keep the arc as short as possible.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %	Mo %
0.12 Max	1.0-1.75	0.80	0.030 Max	0.030 Max	0.90 Max	0.25-0.45

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT – 50 ° C(J)
560 – 660	460 – 570	19 %	27 Joules Min

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 X 350	150	600	AC / DC (+)	70 – 90
3.15 X 450	100	400		90 – 130
4.00 X 450	70	280		140 – 180
5.00 X 450	45	180		180 – 220