

LEADER THERM (Ni) SPL (E 8018 G)AWS : SFA 5.5, E 8018 G
IS : 1395E 55 BG1Ni26**Applications**

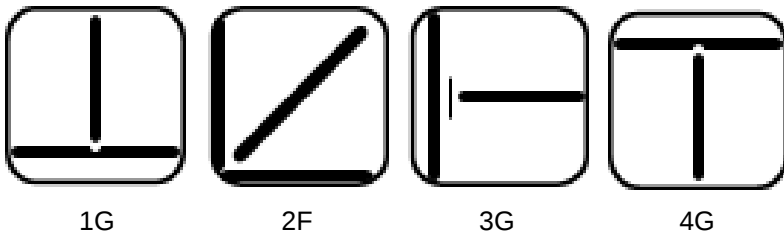
Welding of high strength steel, heavy duty structural fabrication, fine grained, Q & T steel, pressure vessels, tanks, Penstocks.

Characteristics on Usage

A basic coated low hydrogen iron powder type electrode. it is used for welding heavy section of fine grained, high strength steel. It's running very smooth and easy slag removable, yielding a weld deposit containing 1.50%Mn and 0.7%Ni. it gives radiographic quality and low temperature service down to minus 60°C.

Notes On Usage

- ✍ 1) Dry the electrodes at 350 -400°C for 60 min before use.
- ✍ 2) Keep the arc as short as possible .
- ✍ 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose because arc striking on the base metal is in danger of initiating cracking.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	1.00 Min	0.80 Min	0.030 Max	0.030 Max	0.30 Min	0.50 Min	0.20 Min

Mechanical Properties Of Weld Metal

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	Hydrogen (Mercury method)	Reduction Area %
(N/mm ²)	(N/mm ²)	(L = 4d) %	AT – 50 ° C (J)	in 100grm weld metal	
550 Min	460 Min	19 % Min	40 Joules Min	5 ml (Max)	50 - 80

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	200	800	AC / DC (+)	70 – 90
3.15 x 450	100	400		90 – 120
4.00 x 450	70	280		110 – 150
5.00 x 450	45	180		150 – 200