MOLYTEN

LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.5 E7018-A1

CLASSIFICATION:

EN ISO 3580-A
E Mo B 32 H5

IS 1395
E49B-A1

KEY FEATURES:

- Basic coated electrode
- Good creep rupture strength at elevated temperature up to 550°C
- High recovery electrode
- Preheat and PWHT at 620°C is required
- Radiographic quality welds
- All position capability

APPROVALS: ABS/IBR/NPCIL/BHEL/NTPC/CE

TYPICAL APPLICATIONS:

- Welding 0.5 Mo and 1 Cr - 0.5 Mo steels and similar composition steels
- High temperature and high pressure boilers
- Chemical industries, Oil refining industries, Turbine casting
- Suitable for 15Mo3, 16Mo3, 14Mo6
- Joining ASTM SA 182/182M Gr.F1, SA 204/204M Gr.A, SA 209/209M Gr.T1/T1A/T1B, SA 217/217M Gr.WCI

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Mo
0.06	0.7	0.4	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 0°C, J
Typical	PWHT: 620°C for 1 hr.	550	460	27	80
Specification		490 min.	400 min	22 min	-

Hardness (3 Layer): 220 BHN max

Diffusible H2 Content: <5 ml/100 gm

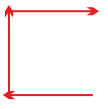
PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A
2.5 x 350	50-80
3.15 x 450	90-130
4.0 x 450	130-110
5.0 x 450	180-240

AC (70 OCV)/DCEP

REDRYING CONDITION:
250-300°C for minimum 1 hr.

All Positions, except Vertical Down



Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW	SAW	
		Flux	Wire
Automig 70S-A1	Tigfil 70S-A1	Automelt B71	Automelt EA2