



MODI - 9018 M

HIGH TENSILE STEEL ELECTRODE

CLASSIFICATION :

IS : 1395-82 : E 63B-M129 Fe
AWS/A 5.5 : E 9018 M

CHARACTERISTICS :

A hydrogen controlled iron powder type electrode for welding high tensile and low alloy structural steels. It gives a smooth arc, medium penetration, low spatter and easy slag removal. Weld metal exhibits high impact values at sub-zero temperatures.

APPLICATIONS :

- * Pressure Vessels
- * Machinery Parts
- * Automobile Parts
- * Penstocks
- * Earth moving equipments
- * Chemical plants

RECOMMENDATIONS :

Re-dry the electrode at 350°C for one hour or at 250°C for two hours. Keep the redried electrodes in a holding oven at 120°C-150°C. The pre-heat and interpass temperature should be maintained at 120°C.

**CHEMICAL ANALYSIS
OF WELD-METAL(%) :**

C	Mn	Si	Cr
0.10 max	0.80-1.25	0.6 max	0.15 max
Mo	Ni	S	P
0.35 max	1.40-1.80	0.03 max	0.03 max

**MECHANICAL PROP-
ERTIES OF ALL WELD-
METAL (TYPICAL)
(AS PER AWS/ A 5.5) :**

Yield Strength	Ultimate Tensile Strength	Elongation (%)	CVN Impact Values at -51°C
N/mm ²	N/mm ²	(%)	Joules
540-620	620-700	24 min	30 min

CURRENT CONDITIONS : USE AC OR DC (+) ONLY

Size (mm)	2.5x350	3.15x450	4.0x450	5.0x450	6.3x450
Amps	70-100	100-140	140-180	190-240	240-280

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