

TECHNICAL DATA SHEET

BRAND NAME: MANGALAM E 7018

Classification:

AWS A /SFA 5.1 E 7018

IS 814:2004 EB5426H3JX

Approval: IBR, DNV.

DESCRIPTION AND APPLICATIONS:

Basic Coated low hydrogen iron powder all position electrodes for radiographic quality welds subjected to restraint. Resists hot & cold cracking. Weld is strong, ductile & tough. Metal recovery 115 %

Typical applications:

- Heavy structures subject to dynamic loading
- Pressure parts in thermal plants
- Boilers, pressure vessels & Pipes
- Bridges, shipbuilding, Coaches & wagons
- Penstock & earth moving machines

CHEMICAL COMPOSITION OF WELD METAL (%)::

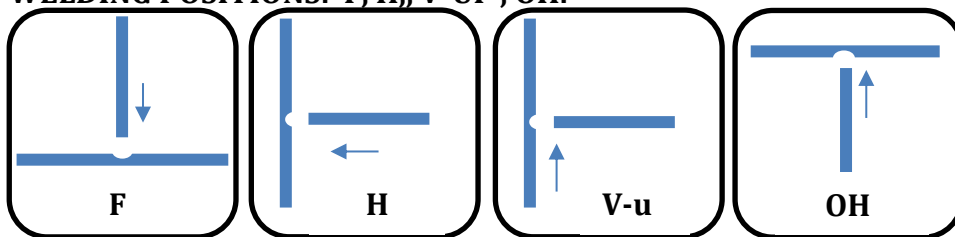
Elements	C	Mn	Si	S	P	Ni	Cr	Mo	V
%	0.12 Max	0.80- 1.60	0.75 Max	0.035 Max	0.035 Max	0.30 Max	0.20 Max	0.30 Max	0.08 Max

MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (N/mm ²)	YS (N/mm ²)	Elongation %	CVN Impact at Minus 30 °C (J)
510 -610	360 Min	20 Min	27 Min

Bend Test 3 T 180°	Satisfactory
Radiography Test II Blue Standard	Satisfactory
Storage Stability	Satisfactory
Diffusible Hydrogen per100 gm weld metal	5 ml Max

WELDING POSITIONS: F, H,, V-UP , OH.



CURRENT CONDITION: AC/ DC (+)

PACKING DATA:

Size SWG	SIZE mm	No of electrodes /Packet	No of electrodes /Cartoon	Current in Amps
12	2.50 X 350/450	150	600	80 - 110
10	3.15 X 350/450	100	400	110 - 130
8	4.00 X 350/450	70	280	150 - 200
6	5.00 X 450	45	180	190 - 250