



Low Hydrogen Electrodes for Mild & Medium Tensile Steel ALPHA 7018-G

Characteristics:

ALPHA 7018 G is a low hydrogen iron power type electrodes yielding 0.70% Ni in the weld metal. Electrode is specially designed for excellent notch toughness at sub zero temperature even welded in vertical uphill progression. The weld metal is of radiographic quality and typical Hydrogen content in the weld metal is 3.9ml/100gms.

Applications

Low alloy steels such as Si-Mn steel, Steel containing nickel up to 1.0%, Heavy sections and strained joints, Subjected to dynamic loading.

Typical Weld metal Composition

Element	Percent
C	0.068
Si	0.30
Mn	1.20
S	0.015
NI	0.66
P	0.019

Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation % (L=5d)	CVN Impact Values at -50°C. J	CVN Impact Values at Minus 20°C. J
610	560	26	60 J	80 J

Weld Metal Hydrogen Contents: - < 4.0 ml/100 gram of weld metal deposit.

Classifications:

AWS A5.5:	E 7018-G	
IS :1395	E55BG1Ni26	
DIN 1913 :	E 5155 B 1029(H)	
BS 639 :	E 42 4B 32 (H5)	

Current Range & Packing Data:

Size MM DxL	Current Range (Amps) AC(70V) or DC (+)	Pieces per Packet	Pieces per Carton
5.00x450	150-200	40	160
4.00x450	120-150	70	280
3.15x450	90-120	100	400
2.50x350	60-80	150	600

Welding Instructions: - Re-Dry the electrode at t 250^o C to 300^o C for 02 hrs.

Approvals : RDSO AS PER IRS M-28/2017 CLASS E2

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