

SUNTHERM 8018 W2

Corrosion Resistant Electrode



CLASSIFICATION

IS 1395-82 : E55B-G126
AWS/A 5.5 : E 8018 W2

CHARACTERISTICS

A special basic type electrode for welding of low alloy, copper bearing corrosion resistant structure steels. The electrodes operate equally well on DC(+) and AC 70 V. Welds are of radiographic quality.

APPLICATIONS

Weathering steels like CORTEN A and B equivalent grades, Medium tensile corrosion resistant structural steel, welding of High tensile steels.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus	Chromium	Nickel	Copper
0.072	0.74	0.42	0.019	0.020	0.58	0.59	0.50

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	CVN Impact Values at minus 18°C/minus 27°C
484.0 N/mm ²	592.0 N/mm ²	23.41%	58.4%	54 Joules avg/ 130 Joules avg

PACKING DATA:

Size (mm)	Length (mm)	Current (Amp) AC 70 V or DC (+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard Box
2.50	350	70-100	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg
6.30	450	240-300	5 Kg	20 Kg

RECOMMENDATIONS:

Re-dry the electrodes at 350°C for one hour or at 250°C for two hours. Keep the re-dried electrodes in a holding oven having 60-80°C temperature. Use short arc to the extent possible.