

ULTRACORTEN I

AWS A/SFA 5.5 E7018-W1

LOW ALLOY STEEL (High Temperature)

KEY FEATURES:

- Basic type iron powder electrode
- Cr-Ni-Cu type low alloy steel welds
- Radiographic quality weld deposit
- Exhibits excellent atmospheric corrosion resistance
- High crack resistance under restraint
- All position capability

TYPICAL APPLICATIONS:

- Welding of weathering steels e.g. CORTEN-A and CORTEN-B and their equivalents
- Bridges, Architectural structures, Exhaust gas flues, Chimneys
- Suitable for ASTM A242 and A588

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


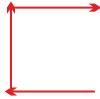
C	Mn	Si	Cr	Ni	Cu	V
0.035	0.65	0.6	0.25	0.3	0.5	0.005

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Specification	As Welded	490 min	415 min	22 min	47 min

Diffusible H₂ Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
3.15 x 450	100-140	 DCEP All Positions, except vertical Downwards  REDRYING CONDITION: 250-300°C for minimum 1 hr.
4.0 x 450	140-180	
5.0 x 450	190-250	

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