

ULTRACORTEN III

AWS A/SFA 5.5 **E8018-W2**

LOW ALLOY STEEL (High Temperature)

CLASSIFICATION:

EN ISO 2560-A
E 46 2 Z B 32 H5

KEY FEATURES:

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

APPROVALS: CE

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 A36, A283 Gr.B/C

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


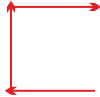
| C | Mn | Si | Ni | Cr | Cu |
|------|-----|-----|-----|-----|-----|
| 0.04 | 1.0 | 0.6 | 0.5 | 0.5 | 0.5 |

MECHANICAL PROPERTIES OF ALL WELD METAL:

| | Condition | UTS, MPa | YS at 0.2% offset, MPa | EL% | CVN Impact at -20°C, J |
|---------------|-----------|----------|------------------------|--------|------------------------|
| Typical | As Welded | 605 | 460 | 22 | 66 |
| Specification | | 550 min | 520 min | 19 min | 47 min |

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

| | | | |
|---|--|--|---|
| <p>Ø x L, mm</p> <p>3.15 x 450</p> <p>4.0 x 450</p> <p>5.0 x 450</p> | <p>Amperage, A</p> <p>100-140</p> <p>140-180</p> <p>190-250</p> | <p> AC (70 OCV) / DCEP</p> <p>REDRYING CONDITION: 250-300°C for minimum 1 hr.</p> | <p>All Positions, except vertical Downwards</p>  |
|---|--|--|---|

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