

VALIANT

VALIANTTHERM HT-SPL.

AWS:A5.5:E11018M 1395E68BM229Fe

A basic coated, extra low hydrogen controlled, low alloyed high tensile steel electrode. The weld metal possesses excellent strength coupled with toughness. Electrode is of radiographic quality, gives low spatter, fine bead appearance, slag detach ability is easy.

CHEMICAL COMPOSITION

C	Mn	Si	Ni	Mo	Cr
0.06	1.35	0.36	2.10	0.40	0.25

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	YS (Kg/mm ²)	EI (L = 4D)%	CVN Impact strength at 51°C
79.0	70.0	21.0	40 J

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	5.00 X 350	180-240
	4.00 X 350	140-180
	3.15 X 350	90-140
	2.50 X 350	50-90

APPLICATION

Suitable for crack resistant, high strength coupled with impact resistance strength at sub-zero temperatures service weld joints, earth moving machinery, heavy structures made of high tensile steels, penstocks etc.

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