

VALIANT

VALIANTTHERM - 7018 - I

AWS:A5.1 :E 7018-1 IS: EB 5426 H₂X

valianttherm - 7018 - 1 is an iron powder low hydrogen type electrode producing a tough and ductile weld metal for welding heavy and rigid structure subjected to dynamic loading and impact. The weld metal is of radiographic quality and displays remarkable impact strength even at minus 50°C.

CHEMICAL COMPOSITION

C	Mn	Si
0.06	1.40	0.25

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	YS (Kg/mm ²)	EI (L = 4D)%	CVN Impac strength at (Joules) 50°C
53.0	46.0	28.0	50 J

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	5.00 X 450	220-280
	4.00 X 450	150-180
	3.15 X 450	100-135
	2.50 X 350	80-100

APPLICATION

Typical application include welding of carbon steels, sensitive to hydrogen embrittlement, heavy and rigid structures, j pressure vessels and! equipments subjected to severe stress and requiring good toughness properties at sub zero temperatures down to - 50°C.

INDIA

Decolite Industries
73, Pologround,
Industrial Estate
Indore, M.P. 452015, India

UAE

Blasting Equipments and Abrasive Trading
Ras Al Khaimah, UAE
Tel: +97-1-552875841, +97-1-552875840
E mail: info@valiantweld.com

E-mail

mkt@valiantweld.com
robin@sptwelding.com



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