

# VALIANT

## VALIANTTHERM-HT

AWS:A5.5:E9018G IS-1395: E63 BG 129Fe

A basic type, medium heavy coated, hydrogen controlled, iron powder electrode for welding high tensile structural steels, heavy sections, restrained joints in high tensile steels. It gives smooth arc low spatter, easy slag detach ability, medium penetration. Welded joints are of radiographic quality.

### CHEMICAL COMPOSITION

C	Mn	Si	Ni	Mo
0.07	1.25	0.40	1.40	0.52

### MECHANICAL PROPERTIES

UTS (Kg/mm <sup>2</sup> )	YS (Kg/mm <sup>2</sup> )	EI (L = 4D )%	CVN Impact strength at 51°C
68.0	59	22 CVN	40 J

### WELDING PARAMETERS

	Size (mm)	Current (Amp.)
AC/DC (-)	5.00 X 450	200-250
	4.00 X 450	140-190
	3.15 X 450	100-140
	2.50 X 350	70-100

### APPLICATION

Typical application includes welding of grain refined steels, Q and T steels, HSLA steels, penstocks, tanks, pressure vessels, structural fabrications.

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