



Electrode for High Tensile Low Alloy Steel ALPHA 11018 M

Characteristics:

Alpha 11018-M is a basic coated, extra low-hydrogen type electrode specially suited for Welding low alloy high tensile steels, Q & T steels like Welten 80, USS T1 , SA 517 Grades and their equivalents. The extra low-hydrogen Contents ensure complete freedom from hydrogen induced cracking in the weld deposit. The weld deposit also displays good impact strength at sub-zero temperatures down to minus 50°C. The electrode operates with ease in all positions.

Applications

Suitable for welding of low alloy high tensile steels, Nickel steels, Ni-Moly steels, steels such as T-1, NA-XTRA, 70, HY100, Q2(N), boilers, pressure vessels, Penstocks ,earth moving equipment and welding of high tensile fine grained steels, NA XTRA 80 etc.

Typical Weld metal Composition

Element	Percent
C	0.06
Si	0.35
Mn	1.52
S	0.018
P	0.020
Ni	2.30
Cr	0.25
Mo	0.40

Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation % (L=5d)	CVN Impact Values at Minus 50°C. J
860	720	22	70 J

Weld Metal Hydrogen Contents: - < 4.0 ml/100 gram of weld metal deposit

Classifications: AWS /A5.5: E 1108 M

Current Range & Packing Data:

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640

Welding Instructions:

- i) Hold a short arc, deposit stringer beads and use minimum current.
- ii) Maintain inter-pass temperature at 100 -120 °C
- iii) Re-Dry the electrode at t 250° C to 300 °C for 02 hrs . Cool them in the same Oven to about 100° C. Transfer them to a holding Oven maintained 50° C to 70 °C and draw them Straight for use

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