



Electrode for High Tensile Low Alloy Steel ALPHA 9018 G

Characteristics:

Alpha 9018-G is an extra low-hydrogen iron powder type electrode specially suited for Welding structural steels having tensile strength between 650 – 700 N/mm². The weld deposit possesses excellent toughness at sub-zero temperatures down to minus 500C. The electrode operates with ease in all positions.

Applications:

The special field of its application comprises Tanks, Penstocks, Pressure vessels & HSLA steels.

Typical Weld metal Composition

Element	Percent
C	0.06
Si	0.35
Mn	1.65
S	0.018
P	0.020
Ni	1.70
Mo	0.30

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 -50°C. J
690	580	22	60 J

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

Classifications:

AWS /A5.5:	E 9018 G
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Current Range & Packing Data:

Size MM DxL	Current Range (Amps) AC-90 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: - Re-Dry the electrode at t 250° C to 300 °C for 02 hrs.

Contact us:-ALPHA ARC PVT. LTD.

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