

# ULTRACORTEN IV

AWS A/SFA 5.5 E 8018-G

LOW ALLOY (Weathering Steel)

## KEY FEATURES:

- Basic type iron powder electrode
- Ni-Cu alloyed weld deposit
- High crack resistance under restraint
- Good toughness properties at -50°C
- Exhibits good corrosion resistance to sea water and flue gases
- Radiographic quality weld deposit
- All position capability

## TYPICAL APPLICATIONS:

- Welding of weathering steels like Corten steels and equivalent base materials
- Ship hull structural steels, Exhaust gas flues

## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


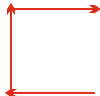
C	Mn	Si	Ni	Cu
0.05	1.0	0.4	0.68	0.45

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	610	530	24	>60

Diffusible H<sub>2</sub> Content: <5 ml/100 gm

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 450 4.0 x 450	<b>Amperage, A</b> 75-110 100-150 130-200	 <b>AC (70 OCV)/DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
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Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing