



MOLYTEN

CLASSIFICATIONS

AWS A/SFA 5.5 E 7018-A1 EN 1599 E Mo B 42 H10
 IS 1395 E 49 B-A1-26 Fe
 DIN 8575 E Mo B 20+

COATING TYPE: Basic DEPOSITION EFF., %: ~110
 COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode for welding of 0.50% Mo creep resistant steels. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal of X-ray quality.

TYPICAL APPLICATIONS

Welding of 0.50% Mo and 0.50% Cr- 0.50% Mo steels used in pressure vessels, boilers and pipelines. Suitable for joining F1 grade of SA-182/182M (P. No.3) Gr. A of SA 204/204M, Gr. T1/T1A/T1B of SA 209/209M, Gr. WCI of SA 217/217M etc.

APPROVALS

ABS E7018-A1 NPCIL E7018-A1
 IBR E7018-A1 PDIL E 7018-1
 Toyo E7018-A1

CURRENT CONDITIONS: AC(70V), DC (+)
 6.3 5.0 4.0 3.2 2.5
 260- 190- 140- 100- 60-
 310 250 180 140

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour
 (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

MECHANICAL PROPERTIES- ALL-WELD					
Condition	UTS MPa	YS MPa	% Elong. (L=4xd)	CVN Impacts,J 27°C	Hardness, BHN
PWHT	510-610	425-520	25-30	140-200	200 max.

PWHT: Post weld heat treated at 620°C for 1 hr

WELD METAL CHEMISTRY, wt%		
C - 0.05-0.09	S - 0.030 max.	Diffusible H 2
Mn - 0.50-0.90	P - 0.030 max.	Content ml/100gm
Si - 0.25 - 0.55	Mo - 0.40-0.65	<5

PACKING DATA				
Dia.,mm	6.3	5.0	4.0	3.2
Length,mm	450	450	450	450
Wt. per carton, kgs	5.25	5.25	5.25	5.25
Cartons/ box	4	4	4	4
Wt. per box, kgs	21	21	21	21

Related Products: Tigfil-70SA1, Molyten-Ti, Automig FC 350, Automelt FC 350 + B41 flux