Estd. 1966

sécheron

Complete Welding Support

ULTRATHERME-M

CODIFICATION:

AWS : SFA 5.5 E11018M

EN ISO : 18275-B E7618-N4M2 A H5

CHARACTERISTICS AND APPLICATIONS:

- Basic coated hydrogen control electrode with a stable and smooth arc that is easy to strike and restrike.
- Low spatter and good bead finish.
- Welds are of radiographic quality.
- The weld metal displays good crack resistance and produces sound weld metal possessing excellent strength combined with good impact properties at subzero temperature.

It is ideally suited for welding high strength Q & T steels like WEL-TEN 80, SA 517 grades and their equivalents. The electrodes are ideally suited for welding restrained joints in high strength steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	0.060	1.50	0.40	0.020	0.020	0.20	2.00	0.40

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact Strength at minus 50°C (Joules)
790	705	22.0	30

CURRENT AND PACKING DATA: DC (+)

Size (mm) Dia x Length	5 x 450	4 x 450	3.15 x 450	2.5 x 350
Current Range (Amps)	180-240	140-180	90-140	50-90
Qty.(Pcs./Carton)	35	55	75	125

APPROVAL: CE

PRECAUTIONS:

1. Redry the electrodes at 300°C for one hour.
2. During welding the heat input should be kept to a minimum. Preheat and interpass temperature shall never be more than 120-150°C.
3. Use stringent beads and minimize weaving.

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