



ULTRATHERME

CODIFICATION: AWS : SFA 5.5 E11018-G

CHARACTERISTICS AND APPLICATIONS:

Ultratherme is a low hydrogen type electrode ideally suited for welding high strength steels, fine-grained steels, HSLA, Q&T steels, etc. The weld metal possesses high strength combined with good toughness properties. Ideal for welding high strength steels used in earth moving industry, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Mo	Ni	Cr	S	P
Percent :	0.06	1.4	0.25	0.50	2.20	0.20	0.018	0.018

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at minus 40°C (Joules)
782	683	19	30

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm) Dia x Length	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Current Range (Amps)	:	280-350	200-260	140-190	100-150	70-100
Qty.(Pcs./Carton)	:	25	35	55	75	125

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
2. Use short arc and minimise heat input during welding.