

# JACKSUN - 18H

## LOW HYDROGEN WELDING ELECTRODE FOR MILD & MEDIUM TENSILE STEELS

### GRADES

AWS / SFA 5.1 E 7018  
IS 814 EB 5426 H3 JX

### CHARACTERISTICS

A basic coated, low hydrogen, iron powder type all position electrode, operates on both AC & DC. The slags are easily removable and the welds are of radiographic quality. The weld metal possesses good mechanical properties.

### APPLICATIONS

An ideal electrode for all types of fabrication including heavy joints under restraint and joints subject to dynamic loading. Typical for pressure vessels, boilers, pipelines, ship building, wagons, coaches, earth moving equipments, atomic reactor shells, blast furnace steel work, penstocks, heavy machinery, cranes, tanks and vessels.

### WELD CHEMISTRY

**CARBON** - 0.15% max

**MANGANESE** - 1.60% max

**SILICON** - 0.75% max

**PHOSPHORUS** - 0.035 max

**SULFUR** - 0.035 max

**CHROMIUM** - 0.2%

**NICKEL** - 0.3%

**MOLYBDENUM** - 0.3%

**VANADIUM** - 0.08%

### MECHANICAL PROPERTIES

**TENSILE STRENGTH (N/mm<sup>2</sup>)** - 510 - 610 MIN

**YEILD STRENGTH (N/mm<sup>2</sup>)** - 400 MIN.

**ELONGATION (L-5d)%** - 20 MIN.

**CVN IMPACT @ 30°CJ** - 27 AVG MIN

### WELDING CURRENT

**DC(+) / AC 70V**

\* **2.00 mm** - 60 - 100 Amps

\* **3.15 mm** - 100 - 140 Amps

\* **4.00 mm** - 140 - 190 Amps

\* **5.00 mm** - 190 - 250 Amps

## PACKING DATA

Size (mm)	1 BOX	1 CARTON
2.5 x 350	150 Pcs	4 Boxes (600 Pcs)
3.15 x 450	120 Pcs	4 Boxes (480 Pcs)
4 x 450	80 Pcs	4 Boxes (320 Pcs)
5 x 450	55 Pcs	4 Boxes (220 Pcs)

## APPROVALS

**BIS, IBR, BHEL, IRS Gr.3 YHH, ABS Gr.3YH5, DNV Gr.3 YH5,  
Ordnance Factory Medak, Cethar Vessels, APPGCL**

## CONTACT

### **ROYAL WELDING WIRES PRIVATE LIMITED**

#### **An ISO 9001 - 2015 Certified Company**

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