



JACKSUN - 18H

C-Mn STEEL (Low Hydrogen)

Welding Electrode for Structural Welding Application

CLASSIFICATION:

EN ISO 14341-A

AWS A/SFA 5.18

APPROVALS

E 42 3 B 32

E-7018

CE / BIS/IBR/BHEL/IRS/
Gr.2, DNV Gr.2,
Ordnance, Factory Medak,
Cethar Vessels, APPGCL

KEY FEATURES :

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

WELDING POSITION :



AC (50 OCV min.)/ DCEN

TYPICAL APPLICATIONS :

- Typical for pressure vessels,
- Pipelines, ship buildings.
- Wagons, coaches, earth moving equipments.
- Atomic reactor shells.
- Blast furnace steel work, penstocks.

REDRYING CONDITION : 250-300OC for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	S	P
Typical Value	0.05-0.10	0.80-1.60	0.30-0.75	0.03	0.03
Specification	0.15 max	1.60 max	0.75 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

Condition		UTS, Mpa	YS at 0.2% offset, Mpa	EL%	CVN Impact at -0°C, J
Typical	As Welded	510-650	490 - 530	24-28 min	27 J
Specification	As Welded	490 min	400 min	20 min	50 - 70 J

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-100	150	4	15.5
3.15 x 350	100 - 140	120	4	21.5
4.0 x 450	140-190	80	4	22
5.0 x 450	190-250	55	4	22



JACKSUN - 18H SPL

C-Mn STEEL (Low Hydrogen)

Welding Electrode for Structural Welding Application

CLASSIFICATION: EN ISO 14341-A AWS A/SFA 5.18

APPROVALS

E 38 2 B 32

E-7018 -1

CE / BIS/IBR/BHEL/IRS/
Gr.2, DNV Gr.2,
Ordnance, Factory Medak,
Cethar Vessels, APPGCL

KEY FEATURES :

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

WELDING POSITION :

WELDING POSITION :



AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Typical for pressure vessels,
- Pipelines, ship buildings.
- Wagons, coaches, earth moving equipments.
- Atomic reactor shells.
- Blast furnace steel work, penstocks.

REDRYING CONDITION : 250-300OC for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	S	P
Typical Value	0.07	1.0	0.5	0.02	0.02
Specification	0.10 max	1.60 max	0.75 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

Condition		UTS, Mpa	YS at 0.2% offset, Mpa	EL%	CVN Impact at -45°C, J
Typical	As Welded	525	440	26	42 - 70 J
Specification	As Welded	520 - 640	410 - 540	24 min	47°

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/B ox	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60-100	150	4	17
3.15 x 350	100 - 130	120	4	28
4.0 x 450	140-180	80	4	57
5.0 x 450	180-240	55	4	88