

ESL'ARC - 18.8MN

Classification

Class -

IS : 5206-03

AWS -

E18.8MnR26

Applications

For joining of manganese steel liners and other austenitic manganese steel components with steel casting to IS : 1030-98 GR.230-450W/280-520W or to IS : 2062-11, welding of high alloy steel armour plates etc.

Characteristics

An electrode for depositing 18.8,5Mn Stainless steel type of weld metal. The weld metal has excellent heat resistant properties. Weld metal is of radiographic quality. There is excellent arc stability and low spatter loss. Weld beads are smooth, uniform and of excellent appearance.

Welding Current (AMPS) AC or DC (D+A70V)

5.00X350mm	4.00X350mm	3.15X350mm	2.50X350mm
150 - 200	110 -150	80 -110	50-75

Weld Metal Analysis (Average Value):

C%	Mn.%	Si%	S%	P%	Ni%	Cr%	Mo%
0.20 Max	5-8	0.90 Max	0.03 Max	0.04 Max	7-10	17-20	0.50 Max

Mechanical Properties of Weld Metal (Average Value):

UTS	Elongation L = 5.65√A
570 N/mm ² min	30% min



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