ESAB 118

A low hydrogen, low alloy electrode for welding low alloy, high strength structural steels

Print

Classification AWS A5.5: E 11018-M
IS 1395: E76BM 326Fe

DESCRIPTION

ESAB 118 is an extra low-hydrogen controlled, low-alloy high tensile steel electrode suitable for welding fully killed fine grained steel giving a tough weldmetal without the risk of temper brittleness. The all position electrode has excellent arc and current carrying characteristics, with an easily removable slag and excellent bead finish contributing to its immense welder appeal.

WELDING CURRENT: DC, AC 70V

TYPICAL APPLICATIONS

ESAB 118 is widely used for welding of low alloy high strength structural steels including quenched and tempered steels such as USS T1, heat treated fine grained steels like N-A-XTRA 70, HY80 and ASTM A517 grade F generally used for penstock, earth moving equipment and other heavy steel fabrications.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.05	Mo	0.40	YS	720 N/mm^2
Mn	1.60	Cr.	0.25	UTS	800 N/mm^2
Si	0.45	S	0.018	EL (L=4d)	22%
Ni	2.00	P	0.018	Impact (CVN) at -51°C	65J

Diffusible Hydrogen =1.9ml/100gm of weldmetal

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-100	130	520
3.15	450	90-125	90	360
4.00	450	120-180	60	240
5.00	450	160-240	40	160

PACKING: Electrodes are packed in cartons and four of these cartons are shrink-wrapped in a cardboard box.