ESAB 98

A low alloy electrode for welding high tensile low alloy steels

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Classification AWS A5.5: E 9018-M
IS 1395: E63BM 126Fe

DESCRIPTION
ESAB 98 is a heavy coated, hydrogen controlled, iron powder type electrode for welding high tensile, low alloy steels depositing x-ray quality, crack resistant welds. The addition of iron powder permits higher currents to be used and results in improved arc characteristics coupled with higher metal recovery. The current characteristics are smooth with excellent operability in all positions and excellent slag removal.

WELDING CURRENT: DC+, AC 70V(min)

TYPICAL APPLICATIONS
ESAB 98 finds extensive use in pressure vessels, piping, penstock, earth moving equipment, machinery parts, automobile parts, chemical plants where low alloy Ni-Cr-Mo steels are used. Suitable for N-A-XTRA 55 and N-A-XTRA 60 steels.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.05	Mo	0.30	YS	590 N/mm^2
Mn	1.00	S	0.020	UTS	650 N/mm^2
Si	0.50	P	0.020	EL (L=4d)	26%
Ni	1.70			Impact (CVN) at -51°C	47J

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.