

ESAB 98 G



A low alloy Electrode for welding High tensile low alloy steel.



Classification

A/AWS 5.5 E 9018G
IS 814 E 63 BG 129 Fe
BS 611 H
DIN E Kb

DESCRIPTION

ESAB 98 G 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 current to be used and result in improved arc characteristics coupled with higher metal recovery. The current characteristics are smooth with excellent operability in all position and excellent slag removal.

WELDING CURRENT: DC+, AC 70V

TYPICAL APPLICATIONS

ESAB 98 G finds extensive use in pressure vessels and pressure part welding, chemical plants where low alloy Ni, Cr, Mo steels is used. Other applications are piping, penstock, automobile parts, earth moving equipment etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Ni	1.60	YS	590 N/mm ²
Mn	1.15	Mo	0.25	UTS	650 N/mm ²
Si	0.35	Cu	0.020	EL (L=4d)	25%
Cr	0.15	S	0.015	Impact (CVN) at -51°C	50J

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
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 cardboard box.