

GM-18

Classification:

IS 814 – 2004 : EB 5426 H3JX
AWS A/ 5.1 : E 7018

Description:

GM 18 is a heavy coated low hydrogen iron powder type electrode ideally suited for producing tough and ductile welds of radiographic quality with minimum 110 % recovery. It has a stable arc with easy slag detachable. Typical hydrogen content 3 ml/100 gms of weld deposit.

Applications:

- ❖ Boilers
- ❖ Earth moving machinery
- ❖ Storage tanks and Pressure vessels
- ❖ Pipelines
- ❖ Rail wagons
- ❖ Penstocks and Blast furnace shells

Chemical Composition of Weld Metal (WT.%):

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.30 Max	0.20 Max	0.30 Max	0.080 Max

Mechanical Properties of Weld Metal:

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation (%)	CVN Impact Values at -30°C
400 Min	490 Min	22 Min	27 Joules Min

Current Conditions:

AC (70 V) / DC (+)

Size (MM)	2.50 X 350	3.15 X 450	4.00 X 450	5.00 X 450
Current (Amps.)	70 - 100	90 - 140	140 - 180	180 - 240

Welding Positions:

F, H, V-up, OH

Recommendation:

Redry electrodes at 300°C for one hour or at 250°C for two hours. Keep the redried electrodes in an oven having temperature 70-100°C and use directly from the oven.

Caution:

Protect yourself and others. Fumes & gases can be dangerous to health. Arc rays can injure eyes and burn skin. Electric shock can kill. Refer American National Standard Z49.1 "Safety in welding and cutting".

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