SMAW

AceWeld LH-18

For 490MPa High Tensile Steels

CLASSIFICATIONS:

AWS A5.1	: E7018 H4R
EN ISO 2560-A	: E 42 3 B 32 H5
EN ISO 2560 - B	: E 49 18 A U H5
JIS Z3211	: E4918 H5

WELDING POSITIONS :

- **Basis Iron Powder Coating with Low Hydrogen Status.**
- **All Position Capabilities Except Vertical Down Position**
- **Superior Weldability And Reliability For The Critical Welding of C-Mn Microlloy And Low Alloy Structure Steels.**

DESCRIPTION AND APPLICATIONS

AceWeld LH-18 is a smooth running basis iron powder, moisture resistant and low hydrogen electrode offering outstanding performance in all position (except vertical down) on both AC and DC welding current. It has very stable arc, good striking & re striking, low spatter level and easy slag detachability.

Electrode produce tough and ductile weld radiographic quality with about 115% metal recovery and excellent low temperature toughness at temperature down to -40°C in the welded and stress relieved conditions.

Typical application include the welding of pressure vessels, pipes, heavy structure beams, tanks, earth moving and mining equipment, repair and maintenance.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	P	S
0.07	1.10	0.45	0.022	0.015

- Diffusible Hydrogen Content : 4 ml/100gms of weld metal max
- Moisture as conditioned : 0.30 max

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
470 N/mm2	560 N/mm2	28%	70J @ 30°C

- in “as welded” condition.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE(amps.)	PACKAGING (KG)	
			PKT	CTN
2.6	300	70 - 110	5	20
3.2	400	90 - 140	5	20
4.0	400	140 - 180	5	20
5.0	400	180 - 240	5	20

- Electrodes are Vacuum packed, no need of redrying and can used straight on the job.
- If electrode expose to the atmosphere, re-dry the electrode at 350°C for 1.5hours.
- Keep re-dry electrodes in the holding oven with temperature 70°C – 100°C and use directly from this holding oven.