

ULTRACORTEN III

CLASSIFICATIONS

AWS A/SFA 5.5 E8018-W2

IDENTIFICATION: Name Printed

CHARACTERISTICS

A low-hydrogen, iron-powder electrode for welding of 0.6%Cr-0.6%Ni-0.5%Cu low-alloy steels. Weld metal exhibits excellent atmospheric corrosion resistance. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-ray quality.

TYPICAL APPLICATIONS

For welding of weathering steels e.g., CORTEN-A and CORTEN-B and their equivalents.

APPROVALS

ABS E 8018-W2

CURRENT CONDITIONS: AC (70V), DC (+)

5.0	4.0	3.2
190-250	140-180	100-140

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 Hr
(Optionally)

WELD METAL CHEMISTRY, (%)

C - 0.10 max.	S - 0.030 max.	Diffusible H ₂
Mn - 0.60 - 1.30	P - 0.030 max.	Content <5 ml/100gm
Cr - 0.45 - 0.70	Ni - 0.40-0.80	of weld metal
Si - 0.35 - 0.80	Cu - 0.30-0.75	

PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	450	450	450
Pcs per carton, Nos	49	79	113
Cartons / box	4	4	4
Pcs per box, Nos	196	316	452
Approx. Wt. of 1000 pcs,kg	102	63	44

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	%Elong.	CVN Impacts,J
	MPa	MPa	(L=4xd)	-20°C
As welded	560-660	480-570	19-26	50-100



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ADOR WELDING LIMITED

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