

ESL'ARC - 78B



Classification

AWS -

E7018 : IS : EB 5426 H₃JX

IRS Class :

B2 as per IRS M:28-2012

Applications

Recommended applications include high pressure piping, boiler & pressure vessels, blast furnace, pen stocks, loco frames, bridges, cranes etc.

Characteristics

A heavy coated low hydrogen iron powder type electrode that has excellent welding characteristics and gives high purity radiographic quality weld deposits. Specially recommended for high strength weld on mild steel, medium carbon and low alloy steels. Deposition efficiency is 115% approx.

Welding Current (AMPS) AC / DC (D+A70V)

6.30x450mm	5.00x450mm	4.00 x 450mm	3.15x450mm	2.5x350mm
270 - 340	200 - 250	150 - 200	100 -140	70 -100

Typical chemical composition of all weld metal:

C%	Mn.%	Si%	S%	P%
0.12 Max	1.60 max	0.75 Max	0.035 Max	0.035 Max

All Weld Metal Mechanical Properties (Average Value):

UTS	YS	% of RA	Impact	Elongation L = 5D
510 N/mm2 min	350 Min. N/mm2	50 min	47 J at -20°C min	26% Min



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