

JACKSUN 18 SPECIAL H4R

MOISTURE RESISTANT, HYDROGEN CONTROLLED,
VACUUM PACKED, BASIC COATED ELECTRODE

BASIC ALLOY: FE, MN, SI
AWS A/ SFA 5.1 E 7018 H4R
EN ISO 2560-A E 42 3 B 32 H5

KEY FEATURES:

Truly the first indigenous moisture resistant, hydrogen controlled, vacuum packed, basic coated electrode which is welder friendly and is recommended for Welding of mild and medium carbon steel, high strength steel, cast steel and problematic steels. The electrode is vacuum packed and hence does not require expensive redrying at 250°C for 2 hours or a higher temperature. The weld metal is clean and has lowest level of impurities thus having unique properties of resistance to ageing

APPLICATIONS

- All maintenance applications including welding of all types of carbon-manganese steels, high tensile, heavy structures, plants and subject to static or dynamic loading. Can be used as a buffer layer before hard facing

RE-DRY CONDITION:

- No need of drying. The electrodes are vacuum packed hence can be used straight on the job.

CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.050-0.095	0.80-1.40	0.30-0.70	0.030 Max	0.035 Max

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
450 -520	520-600	24-32min	-40C : >60J

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/AC 70V)	Kg/pkt.	Kg/Case
2.50/ 2.40	3/ 32"	70-100	5	20
3.15/ 3.20	1/ 8"	100-130	5	20
4.00	5/ 32"	140-180	5	20
5.00	3/ 16"	190-230	5	20