



FERROCRAFT 61



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress.	450 MPa.
Tensile Strength	545 MPa.
Elongation	29%.
CVN Impact Values	160 J av @ -20°C. 130 J av @ -30°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.06%	Mn: 1.45%	Si: 0.45%
S: 0.010%	P: 0.012%	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

8.5 - 9.0 mls of hydrogen / 100gms of deposited weld metal *.
* Reconditioned for 2 hours maximum @ 300°C.

APPROVALS:

Lloyd's Register of Shipping	Grade 3, 3Y H15.
American Bureau of Shipping	Grade 3H15, 3Y.
Det Norske Veritas	Grade 3Y H10.
American Bureau of Shipping	AWS A5.1 E7018.

- ▲ Basic Coated, Hydrogen Controlled E4818 / E7018 Type Electrode.
- ▲ Excellent Out-of-Position Welding.
- ▲ Reliable Impact Properties to -30°C.
- ▲ BATCH NUMBER Identification.
- ▲ Designed for all positional (especially vertical-up) fillet and butt welding applications on heavier steel sections under high restraint such as machinery parts, pressure vessels, mining equipment, pipework, ship construction and all maintenance and repair work.

Classifications:

AS /NZS 1553.1:	E4818-3 H10.
AWS/ASME-SFA A5.1:	E7018.

Packaging and Operating Data:

AC (minimum 55 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	350	42	65 - 100	5kg	15kg - 3 x 5kg	611342
3.2	380	24	95 - 150	5kg	15kg - 3 x 5kg	611343
3.2	380	24	95 - 150	2.5kg	15kg - 6 x 2.5kg	612343
4.0	380	16	145 - 220	5kg	15kg - 3 x 5kg	611344
4.0	380	16	145 - 220	2.5kg	15kg - 6 x 2.5kg	612344
5.0	450	9	195 - 270	5kg	15kg - 3 x 5kg	611345

- Ferrocrafft 61 is formulated to operate with AC (55 O.C.V min), DC+ or DC- polarity. The preferred polarity for fillet welding and fill and capping passes is DC+.

FERROCRAFT 61 H4 – Hermetically Sealed



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress.	450 MPa.
Tensile Strength	545 MPa.
Elongation	28%.
CVN Impact Values	150 J av @ -20°C. 100 J av @ -40°C. 80 J av @ -50°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 1.50%	Si: 0.35%
S: 0.07%	P: 0.012%	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

3.0 - 3.5 mls of hydrogen / 100gms of deposited weld metal.

APPROVALS:

Lloyd's Register of Shipping	Grade 3, 3YH5.
American Bureau of Shipping	Grade 3H5, 3Y.
Det Norske Veritas	Grade 3YH5.



- ▲ Hermetically Sealed Cans.
- ▲ Highly Basic, E4818 / E7018 Type Hydrogen controlled electrode.
- ▲ Advanced moisture resistant flux coating.
- ▲ Very low "H5 / H4" diffusible hydrogen class.
- ▲ C-Mn weld deposit for reliable impact properties to -40°C.
- ▲ Recommended for critical DC welding applications.
- ▲ Batch Number Identification.

Classifications:

AS /NZS 1553.1:	E4818-5 H5R.
AWS/ASME-SFA A5.1:	E7018-1 H4R.

Packaging and Operating Data:

AC (minimum 55 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Can	Carton	Part No
2.5	350	42	65 - 100	3kg	9kg - 3 x 3kg	614342
3.2	380	24	95 - 150	3kg	9kg - 3 x 3kg	614343
4.0	380	16	145 - 220	3kg	9kg - 3 x 3kg	614344

FERROCRAFT 18-Ni – Hermetically Sealed



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	450 MPa.
Tensile Strength	560 MPa.
Elongation	27%.
CVN Impact Values	130 J av @ -20°C. 80 J av @ -40°C. 60 J av @ -50°C.

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.07%	Mn: 1.20%	Si: 0.25%
Ni: 0.9%	S: 0.007%	P: 0.012%

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

3.0 - 3.5 mls of hydrogen / 100gms of deposited weld metal.

APPROVALS:

Lloyd's Register of Shipping	Grade 3, 3YH5.
American Bureau of Shipping	Grade 3H10, 3Y.
Det Norske Veritas	Grade 3Y H5.



- ▲ Hermetically Sealed Cans.
- ▲ Highly Basic, E4818-G / E7018-G Type Hydrogen Controlled Electrode.
- ▲ Very Low "H5 / H4" Diffusible Hydrogen Class.
- ▲ C - Mn - Ni Weld Deposit for Reliable Impact Properties to -50°C.
- ▲ BATCH NUMBER Identification.
- ▲ Recommended for the critical welding of C-Mn, microalloyed and low alloy structural steels in the 350-450 MPa yield strength class.
- ▲ Applications include the all positional (except vertical down) fillet and butt welding of pressure vessels, offshore platforms, pipes, earth moving equipment.

Classifications:

AS/NZS 1553.2:	E4818-G.
AWS/ASME-SFA A5.5:	E7018-G.

Packaging and Operating Data:

AC (minimum 70 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
3.2	380	18	110 - 145	3kg	9kg - 3 x 3kg	611813
4.0	380	12	140 - 200	3kg	9kg - 3 x 3kg	611814

- Ferrocrafft 18-Ni is formulated to operate with AC (min 70 O.C.V), DC+ or DC- polarity. The preferred polarity for fillet welding and fill and capping passes is DC+.