



HIGH TENSILE STEEL ELECTRODES

PREMIER-8018 G

CHARACTERISTICS :

A heavy coated, all position, hydrogen controlled, iron powder type electrode. It welds with a quiet, stable arc and gives very little spatter. The welds are of radiographic quality.

APPLICATIONS :

Welding of Si-Mn, Ni alloyed fine grained steels and high tensile steels for heavy construction work subject to dynamic loading.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.07
Si	0.4
Mn	1.4
S	0.02
P	0.025
Ni	0.6

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at +20 °C. Kgm
64	53	24	15

CLASSIFICATION :

AWS A5.1 : E 8018 G

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC (70V) or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640



PREMIER-8018 C1

CHARACTERISTICS :

A basic coated, iron powder type electrode, specially designed for welding of 2.5% Nickel steels. The electrode gives a smooth arc, medium penetration & low spatter.

APPLICATIONS :

For welding of 2.5% Ni steels, high tensile steels, pressure vessels, valves, storage tanks and pipelines for liquid gases such as butane, propane etc.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.05
Si	0.3
Mn	0.8
S	0.02
P	0.015
Ni	2.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at 20 °C. Kgm
62	53	24	16

CLASSIFICATION :

AWS A5.1 : E 8018 C1

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC (70V) or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640





HIGH TENSILE STEEL ELECTRODES

PREMIER-9018 G

CHARACTERISTICS :

A medium heavy coated, low hydrogen, all position electrode for welding of heavy sections & restrained joints in high tensile steels. It gives radiographic quality welds.

APPLICATIONS :

For welding of high tensile steels, power house construction, oil refinery, earth moving equipment etc.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.06
Si	0.4
Mn	1.4
S	0.015
P	0.025
Ni	1.0
Mo	0.4

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at +20 °C. Kgm
65	55	21	15

CLASSIFICATION :

AWS A5.1 : E 9018 G

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC (70V) or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640



PREMIER-CHROME 1

CHARACTERISTICS :

A heavy coated, all position, low hydrogen, iron powder electrode with 1.25% Cr. 0.5% Mo. The weld deposit has excellent creep resistance at service temp. upto 550°C..

APPLICATIONS :

Well suited for welding of Chrome-Moly steels in oil refineries, boilers, power houses and repairing of automobile parts and earthmoving equipments.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.06
Si	0.3
Mn	0.7
S	0.017
P	0.02
Cr	1.2
Mo	0.5

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at +20 °C. Kgm
62	53	21	16

CLASSIFICATION :

AWS A5.1 : E 8018 B2

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC (70V) or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640





HIGH TENSILE STEEL ELECTRODES

PREMIER-CHROME 2

CHARACTERISTICS :

A medium heavy coated, basic type, all position, iron powder electrode giving weld deposit resistant upto 650°C. specially designed to weld high tensile Chromium-Molybdenum heat & creep resisting steels.

APPLICATIONS :

Suitable to weld high tensile steels with 2.25% Cr and 1% Molybdenum, boilers, pressure vessels, pipelines in oil refineries, high temperature reaction vessels etc.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.07
Si	0.3
Mn	0.7
S	0.02
P	0.025
Cr	2.2
Mo	1.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at +20 °C. Kgm
67	58	20	15

PREMIER-NMC

CHARACTERISTICS :

A basic coated all position radiographic quality electrode with 1% Cr, 2.5% Ni, 0.7% Mo.

APPLICATIONS :

The electrode has very high tensile strength and is suitable for welding of Ni-Cr-Mo steels, steam turbine rotors & earthmoving equipment etc.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.05
Si	0.4
Mn	1.6
S	0.025
Ni	0.8
Cr	0.2
Mo	0.3

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm2	Yield Strength Kg/mm2	Elongation % (L=5d)	CVN Impact Strength at +20 °C. Kgm
72	63	23	16

CLASSIFICATION :

AWS A5.1 : E 9018 B3

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640



CLASSIFICATION :

AWS A5.1 : E 10016 G

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640





HIGH TENSILE STEEL ELECTRODES

PREMIER-11016 G

CHARACTERISTICS :

A basic coated Ni-Mo alloyed electrode for welding of high tensile steels such as N-A-XTRA 70, HY 100, Q2(N)

APPLICATIONS :

Suitable for all critical applications in high strength steels such as offshore and bridge structures.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.05
Si	0.3
Mn	1.6
S	0.015
P	0.02
Ni	2.0
Mo	0.4

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm ²	Yield Strength Kg/mm ²	Elongation % (L=5d)	CVN Impact Strength at +20 °C. Kgm
75	65	22	16

CLASSIFICATION :

AWS A5.1 : E 11016 G

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640



PREMIER-11018 M

CHARACTERISTICS :

A heavy coated, hydrogen controlled, iron powder type electrode, suitable for welding of high tensile steels having tensile strength of 110,000 psi upwards.

APPLICATIONS :

Suitable for welding of low alloy high tensile steels, Nickel steels, Ni-Moly steels, steels such as T-1, NA-XTRA 70, HY100, Q2(N), boilers, pressure vessels, earthmoving equipment, heavy structures etc.

TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.06
Si	0.3
Mn	1.5
S	0.02
P	0.015
Ni	2.0
Cr	0.2

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm ²	Yield Strength Kg/mm ²	Elongation % (L=5d)	CVN Impact Strength at +20 °C. Kgm
80	71	22	15

CLASSIFICATION :

AWS A5.1 : E 11018 M

CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	250-330	30	120
5.00x450	200-240	45	180
4.00x450	140-190	80	320
3.15x450	100-140	110	440
2.50x350	60-90	160	640

Instructions for All "High Tensile" Products :

- Keep electrodes dry.
- Rebake electrodes at 350°C. for one hour.
- Do not use excessive current.
- Hold short arc.
- Use good fit-up on joints.
- Adopt proper sequence.
- Slow and uniform cooling is recommended.