



# ULTRAWELD PLUS

E7018-1 H4

## LOW HYDROGEN BASIC COATED ELECTRODES

Conforms to Standard AWS 5.1 E7018-1H4;  
BS EN ISO 2560 E4918-1AH5 & JIS Z 3212 D5016

PREMIUM  
QUALITY  
WELD

X-RAY SOUNDNESS & LESS STUB LOSS

BSRM Ultraweld Plus is a basic coated, Hydrogen controlled Iron powder with a thicker flux-coated electrode, designed for welding in all positions. It creates tough weld deposits on mild steel and low alloy steels. Weld deposits have Radiographic quality, easy slag detachability, making it the ideal electrode for welding on rigidly resistant structures, where stress cannot be avoided. It has an extremely smooth and stable arc with good arc striking & re-striking characteristics.

## USAGE:



Nuclear power plant fabrication



Ship building fabrication



Steel bridge fabrication

## KEY FEATURES OF ULTRAWELD PLUS:

- Suitable for steel construction, boiler, shipbuilding
- Electrode coating ratio is high
- Spatter & Fume Formation is low
- Excellent weld bead
- Easy slag detachable
- Excellent strength and toughness
- Weld metal recovery about 120%
- Suitable for all position welding. (1G, 2G, 3G, 4G, 1F, 2F, 3F, 4F) except Vertical down





## TYPICAL MECHANICAL PROPERTIES:

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (J)	Elongation (LO=5d0) (%)
480	560	105 at -45°C	25

## TYPICAL CHEMICAL COMPOSITION OF WELD DEPOSIT (%)

Carbon(C)	Manganese(Mn)	Silicon(Si)	Sulphur(S)	Phosphorus (P)
0.06	1.14	0.30	0.006	0.029



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

**Type of Current:** AC/DC (Minimum OCV 70 Volt)

## OPERATING & PACKING INFORMATION:

Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
2.50	300	2	65–100
3.20	350	3	95–150
4.00	350	3	145–220

## RULES FOR STORAGE:

Keep the electrodes in a dry place. Before using, heat in the oven at 350°C temperature for 90–120 minutes and keep in a holding oven at 100–120°C temperature.

## WARNING:



Avoid inhaling of welding fumes and gases for health



Welding Arc rays can injure eyes & burn skin



Read and understand safety instructions & practices before use



Always weld in an open & well ventilated space with sufficient airflow



Wear protective safety gear for your eyes, ears & body



Always be careful when handling electrical equipment

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