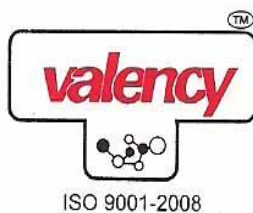


Consumables for Joining & Fabrication of Steels

'Valency' manufactures a range of AWS coded austenitic & Ferritic range of Stainless Steel Electrodes which are widely recognized for superb welding characteristics viz. very low spatter, smooth arcing and excellent slag detachability in addition to superior corrosion resistance.'



PRODUCT CATALOGUE FOR JOINING AND FABRICATION OF STAINLESS STEELS



STICK ELECTRODES

Product	Description	Classification	Applications	Typical Properties	Size and Current				
PRIMEARC-13 [AC/DC+]	RUTILE COATED, ALL POSITION, EASY STRIKING & DETACHABILITY, SMOOTH BEAD, RADIOGRAPHIC WELD	AWS : A 5.1 E 6013/IS 814 ER 4212 X	Pipes, Boilers, Coaches & Wagons, Bridges, Pressure Vessels etc.	UTS. 420-480 N/mm ² Elongation 22% Min., CVN at 0 Deg C 47J	Size (mm) Amps	2.50 60-85	3.15 85-120	4.0 120-160	5.0 160-220
VALENCY LH 76 [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, HIGH STRENGTH, GOOD DUCTILITY & IMPACT STRENGTH, RADIOGRAPHIC WELD.	AWS : A 5.1 E 7016/IS 814 EB 5424H3 X	Low and Medium Carbon Steels, Heavy Sections, Gears, Sprockets etc.	UTS. 550 N/mm ² Elongation 25% Min. CVN at -30 ° C 80J	Size (mm) Amps	2.50 70-100	3.15 100-140	4.0 135-175	5.0 165-220
VALENCY LH 78 [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, HIGH STRENGTH, AROUND 115% RECOVERY, GOOD DUCTILITY & IMPACT STRENGTH UPTO - 30°C, RADIOGRAPHIC WELD FOR DYNAMIC LOAD.	AWS : A 5.1 E 7018/IS 814 EB 5426H3 JX	Low & Medium Carbon Steels, Pressure Vessels, Boilers, Penstocks, Heavy Sections etc.	UTS. 580 N/mm ² Elongation 26% CVN at -30 ° C 100J	Size (mm) Amps	2.50 80-100	3.15 100-150	4.0 150-200	5.0 200-250
VALENCY LH 78 (Spl) [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, LOW ALLOY, HIGH STRENGTH, AROUND 115% RECOVERY, GOOD DUCTILITY & IMPACT STRENGTH UPTO -50°C, EXCELLENT RADIOGRAPHIC QUALITY WELD, SUITABLE FOR DYNAMIC LAOD CONDITION	AWS : A5.1 E 7018-1/IS 814 EB 5626 H3 JX	Low & Medium Carbon Steels, Pressure Vessels, Boilers, Penstocks, Heavy Sections etc.	UTS. 600 N/mm ² Elongation 26% CVN at -30 ° C 110 J	Size (mm) Amps	2.50 80-100	3.15 100-150	4.0 150-200	5.0 200-250
VALENCY LH 78 A1 [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, LOW ALLOY, HIGH STRENGTH, FOR 05% Mo STEELS, CREEP RESISTANCE UPTO 525°C	AWS : A5.5 E7018-A1	Welding of 0.5 Mo steels, plates, pressure vessel pipes etc.	U.T.S. 540 N/mm ² , Y.S. 480 N/mm ² , Elongation 26%	Size (mm) Amps	2.50 75-100	3.15 100-140	4.0 150-190	5.0 190-240
VALMET 8018 B2 [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, LOW ALLOY, HIGH STRENGTH, 1.25Cr/0.5%, MOLYTYPE. CREEP RESISTENCE UPTO 525°C.	AWS : A5.5 E8018 B2	Welding of 0.5 Cr-0.5 Mo steels, 1.00 Cr - 1.00 Mo steels plates, etc.	U.T.S. 570 N/mm ² , Y.S. 520 N/mm ² , Elongation 24%	Size (mm) Amps	2.50 70-100	3.15 100-140	4.0 135-175	5.0 165-220

Product	Description	Classification	Applications	Typical Properties	Size and Current				
VALMET 9018 B3 [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, LOW ALLOY, HIGH STRENGTH DEPOSIT FOR 2.25 Cr/1.0% MOLY TYPE STEELS, CREEP RESISTANCE UPTO 600°C	AWS: A 5.5 : E9018 B3	Welding of 2.25 Cr/1.0 Mo,Cr-Mo-V steels as well as cast steels of similar composition.	U.T.S. 650 N/mm ² , Y.S. 540 N/mm ² , Elongation 22%	Size (mm) Amps	2.50 70-100	3.15 100-140	4.0 135-175	5.0 165-220
VALMET 8018 W2 [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, IRON POWDER, 0.5Cr-0.7Ni-0.5Cu TYPE DEPOSIT, RESISTS HIGH TEMPERATURE ATMOSPHERIC CORROSION.	AWS: A5.5: E8018 W2	Welding of weathering steels like corten steels used in railways, chemical and petrochemical industries.	U.T.S. 600 N/mm ² , Y.S. 520 N/mm ² , Elongation 26%, CVN at -20°C 30 J	Size (mm) Amps	2.50 90-120	3.15 100-150	4.0 135-200	5.0 190-270
VALMET 8018 G [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, IRON POWDER, LOW ALLOY, HIGH STRENGTH DEPOSIT.	AWS : A 5.5 : E8018 G	Welding High Tensile fine grained steels, good impact upto - 30°C	U.T.S. 625 N/mm ² , Y.S. 540 N/mm ² , Elongation 22%,	Size (mm) Amps	2.50 80-110	3.15 110-150	4.0 150-200	5.0 200-260
VALMET 9018 G [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, IRON POWDER, LOW ALLOY, HIGH STRENGTH DEPOSIT.	AWS : A 5.5 : E9018 G	Welding High Tensile fine grained steels, good impact upto - 30°C	U.T.S. 650 N/mm ² , Y.S. 540 N/mm ² , Elongation 22%, CVN at -40°C 30 J	Size (mm) Amps	2.50 80-115	3.15 95-140	4.0 130-190	5.0 180-260
VALMET 11018 G [AC/DC+]	BASIC COATED, ALL POSITION, LOW HYDROGEN, IRON POWDER, LOW ALLOY, HIGH STRENGTH DEPOSIT.	AWS : A 5.5 : E 11018 G	Welding High Tensile steels requiring good toughness properties e.g. HSLA & Q & T steels, earthmoving components etc.	U.T.S. 800 N/mm ² , Y.S. 720 N/mm ² , Elongation 22%, CVN at -40°C 30 J	Size (mm) Amps	2.50 80-115	3.15 95-140	4.0 130-190	5.0 180-260

