

+ Orange 7018 - Moly (AWS Spec. E - 7018 A1)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.075	0.90	0.45	0.03	0.03	●	●	0.55	●	●	425-525	510-660	25-30	120-180	27+2°C

**Application:**

Boilers, Pressure Vessels, Ship Building, Pipes, Welding heavy bridges

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+ Orange 7018 - MolyChrome (AWS Spec. E - 7018 B2)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.075	0.85	0.85	0.03	0.03	1.00	●	0.50	●	●	400-500	510-660	22-28	●	●

**Application:**

Welding of Boiler tubes, Oil refinery pipelines, Super heaters, High temp synthetic Chemical Industries

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+ Orange 7018 - Nickel (AWS Spec. E - 7018 G)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.075	1.20	0.35	0.03	0.03	●	0.05	●	●	●	420-480	510-660	25-30	40-55	-49°C

**Application:**

Welding heavy sections, restrained joints requiring good impact strength at -50°C, Welding fine grained steel containing Nickel upto 1% & welding heavy sections.

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+ Orange 8018 - MolyChrome 1 (E-8018 B2)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.06	0.65	0.40	0.03	0.03	1.25	●	0.55	●	●	480-580	575-675	22-28	50-90	27+2°C

**Application:**

Welding of 1.25% Cr & 0.5% Mo steel, applications include heat & Creep resistant steel, welding on equipment of oil refineries, stamp pipes.

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+ Orange 8018 - Nickel (E-8018 G)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.08	1.50	0.35	0.03	0.03	●	1.00	●	●	●	480-580	575-675	24-30	40-50	-49°C

**Application:**

Welding of high strength Q & T Steels, Pressure Vessels, Penstocks, fine grained steels, Bridges.

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+ Orange 8018 - MolyChrome 5 (E-8018 B6)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.06	0.65	0.35	0.03	0.03	5.00	●	0.50	●	●	460-530	550-650	22-30	●	●

**Application:**

Welding of 5% Cr & 0.5% Mo for high temperature applications in oil refineries, Power plants, Fertilizer & Pharmaceutical Industries.

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+ Orange 9018 - MolyChrome 2 (E-9018 B3)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.08	0.65	0.35	0.03	0.03	2.25	●	1.00	●	●	550-650	630-730	20-28	●	●

**Application:**

Welding of 2.25% Cr, 1% Mo, Used in Oil Refineries, Power Plants, Boilers at temp up to 600°C

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+ Orange 9018 - NicoMoly (E-9018 G)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.08	1.50	0.50	0.03	0.03	●	1.50	0.50	●	●	550-630	630-700	20-28	30-45	-49°C

**Application:**

Welding of high strength low alloy steels, grain refined steels, Structural fabrication, Pressure Vessels.

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+ Orange 10018 (E-10018 M)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.07	1.20	0.35	0.03	0.03	0.50	1.00	0.50	●	●	670-740	775-850	20-25	30-60	-49°C

**Application:**

Welding of high strength steels under conditions of relative high humidity and higher joint restraint to prevent hydrogen induced cracking.

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+ Orange 11018 (E-10018 M)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
0.07	1.50	0.45	0.03	0.03	0.30	2.00	0.50	●	●	680-750	770-850	20-30	30-60	-49°C

**Application:**

Earth Moving Equipments, Petrochemical tanks & Vessels, Submarines, Offshore constructions & Machinery