

PRODUCT DATA SHEET

Afrox 98



Afrox 98 is a basic coated hydrogen controlled electrode for all position welding of high tensile low alloy steels. The electrode deposits a weld metal containing approximately 1,5% nickel and 0,3% molybdenum which apart from having good tensile properties, is extremely tough and ductile. Afrox 98 produces weld metal of the highest radiographic and metallurgical qualities in all positions. The product is recommended for welding a range of fine grained structural steels, low temperature steels and quenched and tempered steels, having an ultimate tensile strength of up to approximately 750 MPa.

Classifications		
AWS	A5.5	E9018-G
EN	757	E55 5 2B 42

Typical Chemical Analysis			
% Carbon	0,04 - 0,08	% Phosphorous	0,025 max
% Manganese	0,7 - 1,2	% Molybdenum	0,2 - 0,35
% Silicon	0,5 max	% Nickel	1,4 - 1,8
% Sulphur	0,025 max		

Typical Mechanical Properties (All weld metal in the as welded condition)	
0,2% Proof Stress	540 - 620 MPa
Tensile Strength	620 MPa min
% Elongation on 50 mm	24 min
Charpy V-Notch at -51°C	45 J min

Packing Data				
Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
3,15	90 - 135	350	3 x 4,0	W075423
4,0	120 - 175	350	3 x 4,0	W075424
5,0	170 - 245	450	3 x 5,0	W075425

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