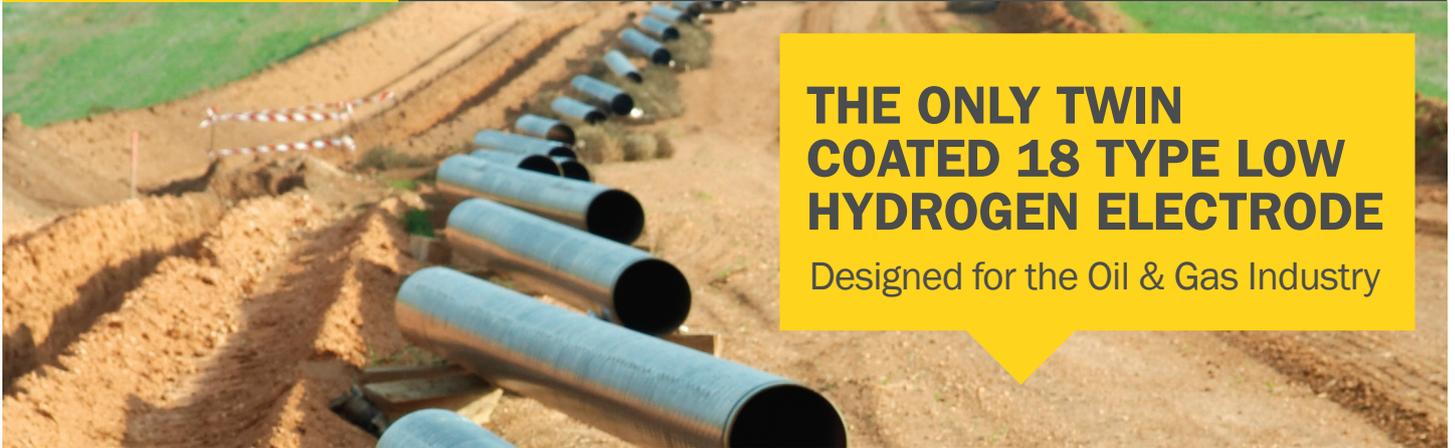




Austarc 18TC Vacuum Packed



**THE ONLY TWIN
COATED 18 TYPE LOW
HYDROGEN ELECTRODE**

Designed for the Oil & Gas Industry

BENEFITS

- Vacuum packs extend on-site storage life
- Hydrogen controlled reduce cold cracking
- Improved low temperature impact reduces in-service cracking

DESIGNED FOR THE OIL & GAS INDUSTRY

Austarc 18TC is a unique product, designed for applications where C-Mn and low alloy steel are applied within the oil and gas industry.

SUPERIOR OPERATOR APPEAL

- Being a twin coated electrode, the 18TC offers superior operator appeal, but does not compromise the mechanical soundness of a low hydrogen electrode.
- The twin coating offers easy strike and re-strike, reducing the chances of weld start and stop defects.
- Its impact toughness is tested to -50 °C, exceeding 47J.
- Twin coating electrodes are renowned for being operator friendly.
- The 18TC takes this further to enhance the ability offering very low hydrogen status and moisture resistance flux coating.

WELD DEFECT REDUCTION

- One of the common pipe weld joint defects is slag inclusion, where tight joint configurations are often found on smaller diameter pipe application. The 18TC slag system offers the benefit of easy slag removal, and significantly reduces the chance of slag inclusion.
- The conventional 18 type low hydrogen electrode produces a grey cement like slag cover after welding, in contrast a glossy dark slag system is produced from the twin coated Austarc 18TC.
- Both the brittle slag nature and dark colour will reduce the chance of slag residual prior to next weld pass.



welding.com.au 1300 300 884



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LOW HYDROGEN H4 STATUS

From relentless research and development, the all new Austarc 18TCH4R is classified as very low hydrogen H4 status meeting the tough requirement of maximum 4ml Hydrogen per 100g of weld metal.

MOISTURE RESISTANCE COATING

The moisture resistance flux coating meets the maximum as-received 0.3% by Wt of flux coating moisture, and maximum 0.4% by Wt after exposure to 27°C and 80% relative humidity.

To ensure all these benefits upon delivery, we offer the complete product line in a hermetically sealed vacuum package.

CLASSIFICATION

- > AS/NZS 4855-B - E49 18-1 A U H5
- > AWS A5.1: E7018-1H4R

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

| | |
|-------------------|--------------|
| Yield Stress | 530 MPa |
| Tensile Strength | 602 MPa |
| Elongation | 24% |
| CVN Impact Values | 87J @ -50 °C |

ORDERING INFORMATION

| AUSTARC 18TC | PART NUMBER |
|-------------------|-------------|
| 2.5MM 2kg Vac Pac | 18TCH4VP25 |
| 3.2MM 2kg Vac Pac | 18TCH4VP32 |
| 4.0MM 2kg Vac Pac | 18TCH4VP40 |

For further information or to organise a demonstration, contact WIA's Customer Support team on 1300 300 884.



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