

S-9018.M

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E9018-M

EN 757 E50 4 B 4 2

ABS AWS A5.5 E9018-M

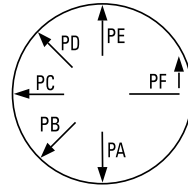
Applications

- Heavy steel fabrication
- Pressure vessels

Features

- Good crack resistance
- Good X-ray performance
- Good impact value at -50°C
- Iron powder and low hydrogen type electrode (high efficiency)

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.05	0.46	1.21	0.017	0.011	1.47	0.22

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
585 (85,000)	646 (93,800)	27.6	-50 (-58)	89 (66)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	70~100	90~140	130~190	180~240	250~300
V-up, OH	60~80	80~120	120~170	150~200	-