

H ZULFI E 11018-G

Brand Name & Classification

AWS/ASME SFA-5.5: E 11018-G
DIN 8529: E Y 69 75Mn2NiCrMoBH5

Approvals Grade

Properties

Electrode for producing crack free and tough welded joints. The weld metal is of extremely high metallurgical purity with very low hydrogen content. Welds are of X-ray quality. Has good toughness properties up to -60° c.

Application

Heat treated fine grain structural steels e.g. Est E 690 and others.

Weld Metal Analysis Typical values

Carbon: 0.06

Silicon: 0.05

Manganese: 1.80

Nickel: 2.20

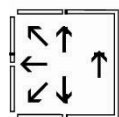
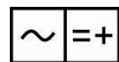
Chromium: 0.40

Molybdenum: 0.40

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>700 N/MM ²	800 – 960 N/mm ²	>17 %	120 J at +20 ⁰ c 60J at -60 ⁰ c

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	350	60-80
3.2	400	80-120
4.0	400	110-150
5.0	400	140-200