

SR ZULFI E 10018-G

Brand Name & Classification

AWS/ASME SFA-5.5: E 10018-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 620, ESt E 690 and others.

Weld Metal Analysis Typical values

Carbon: 0.06

Silicon: 0.50

Manganese: 1.50

Chromium: 00.40

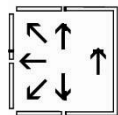
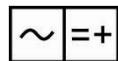
Nickel: 2.10

Molybdenum: 0.40

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
$>700 \text{ N/MM}^2$	780 –940 N/mm^2	$> 17\%$	120 J at $+20^{\circ}$ c 60J at -60° 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