

## H ZULFI E 8018-G

### Brand Name & Classification

AWS/ASME SFA-5.5: E 8018-G  
DIN 8529: E Y 50 76 Mn 1 Ni B H5  
EN 499: E 50 6 1Ni B 42 H5

### Approvals Grade

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### Properties

Electrode for producing crack free and tough welded joints. Gives weld of X-ray quality. Weld metal gives good impact values up to  $-60^{\circ}$  c due to its high metallurgical purity and low hydrogen content. Well suited for positional welding.

### Application

Fine grain structural steels:  
StE 420, StE 460, StE500, WStE 420  
WStE 460, WStE 500  
TStE 420, TStE 460, TStE 500

### Weld Metal Analysis Typical values

Carbon: 0.08

Silicon: 0.40

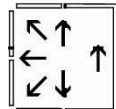
Manganese: 0.90

Nickel: 0.90

### Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>510 N/MM2	590 – 690 N/mm2	> 26 %	150 J at $+20^{\circ}$ c
			60 J at $-60^{\circ}$ c

### Welding Current & Positions



### Current

Dia	Length	Amperes
2.6	350	70-100
3.2	400	90-140
4.0	400	140-190
5.0	400	190-250