

Brand Name & Classification

AWS/ASME SFA-5.5: E 9018-D1

Properties

Electrode for welding of mild and low alloy steels for structures working at low temperatures. Best suited for low alloy steel structures where preheating cannot be applied. The weld metal features good toughness properties up to -60° c.

Application

Fine grain structural steels: StE 420, StE 460, StE500, WStE 420
WStE 460, WStE 500
TStE 420, TStE 460, TStE 500
Cryogenic steels: acc DIN17 173/17 174;
TT St35
TT St 35 V, 10Ni 14

**Weld Metal Analysis
Typical values**

Carbon: 0.06

Silicon: 0.35

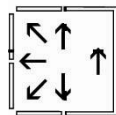
Manganese: 1.50

Molybdenum: 0.35

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>580 N/MM ²	610 – 690 N/mm ²	> 24 %	180 J at +20 ⁰ c 50J at -20 ⁰ 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