

S-10018.D2

Classification

AWS A5.5/ASME SFA-5.5 E10018-D2 H4R

Welding Positions



Features

- Low hydrogen electrode
- Welding 690MPa class Low alloy steel

Polarity

AC or DC +

Application Areas

- Carbon-Manganese and Chromium-Molybdenum steel piping (AISI 4130, 4140)

Redrying Conditions

350~400°C (662~752°F) X 0.5~1hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Mo
0.06	0.42	1.75	0.015	0.007	0.73	0.27

Typical Mechanical Properties of All-Weld Metal

PWHT	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
620°Cx1Hr	646(94)	712(103)	26	-50(-60)	62(46)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
3.2(1/8)	350(14)	90-130	85-120	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
4.0(5/32)	400(16)	130-180	110-170	
5.0(3/16)	400(16)	180-240		

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux