

S-11018.M

Classification

AWS A5.5/ASME SFA-5.5 E11018-M
EN ISO 18275-A E62 4 ZMn2NiMo B 4 2

Welding Positions



Features

- Iron powder and low hydrogen type electrode (high efficiency)
- Good crack resistance
- Good X-ray performance
- Good impact value at -50°C

Polarity

AC or DC +

Application Areas

- Low alloy high tensile steels

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS
✓

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

C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.41	1.49	0.018	0.008	1.99	0.04	0.41

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
707(103)	793(115)	22	-50(-60)	50(37)

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	55-90	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	90-130	80-120	
4.0(5/32)	400(16)	130-190	120-170	
5.0(3/16)	400(16)	190~240	150-200	
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