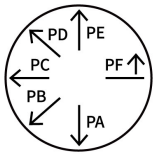


S-8018.C1

Classification

AWS A5.5/ASME SFA-5.5 E8018-C1
JIS Z 3211 E5518-N5 AP L
EN ISO 2560-A E46 5 2Ni B 3 2

Welding Positions



Features

- Good impact value at -60°C
- Iron powder and low hydrogen type electrode (high efficiency)

Polarity

AC or DC +

Application Areas

- Low temperature strength steel (2.5% Ni)
- Offshore structure

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

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

C	Si	Mn	P	S	Ni
0.05	0.31	0.93	0.015	0.008	2.31

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)
605°C*2hr	485(70)	590(86)	27	-60(-75)	82(60)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
3.2(1/8)	350(14)	90-130	80-120	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
4.0(5/32)	400(16)	130-190	110-170	
5.0(3/16)	400(16)	190-250	150-200	
6.0(15/64)	450(18)	250-310	-	