

# S-11018.M

Type : Basic

## Conformances

AWS A5.5/ ASME SFA5.5 E11018-M

EN 757 E62 4 B 4 2

ABS AWS A5.5 E11018-M

## Applications

- Low alloy high tensile steels

## Features

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

## Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

## Current

AC or DC +

## Redrying Conditions

300~350°C (572~662°F) X  
0.5~1hr

## Diameter / Packaging

Diameter	Length	Standard	
		packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)		✓
3.2 (1/8)	350 (14)		✓
4.0 (5/32)	400 (16)		✓
5.0 (3/16)	400 (16)		✓
6.0 (15/64)	450 (18)		✓

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.07	0.48	1.62	0.023	0.012	0.21	2.04	0.35

## Typical Mechanical Properties of All-Weld Metal

Condition	YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.lbs)
AW	722 (104,900)	796 (115,600)	21.6	-50 (-58)	50 (37)

## Typical Operating Procedures

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55~90	90~130	130~190	190~240	250~300
V-up, OH	50~80	80~120	120~170	150~200	-

SMW

SAW

GMW

GTW

FCW

Non-FERROUS

APPENDIX