

10018-D2

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| CATEGORY | SMAW Stick Electrodes | |
| TYPE | High basic low hydrogen electrode for high strength steels. | |
| APPLICATIONS | Recommended for welding high yield strength steel (>600N/mm ²) in case high impact values are required at sub zero temperatures. The ideal electrode for welding MUD pipes in offshore. (Meets NACE requirements) Pipeline according API standard ranging from X65 upto X80. | |
| PROPERTIES | Basic electrode with excellent welding characteristics, Hydrogen content (HD < 3 ml/100 g). Meets NACE requirements MR0175/ISO15156-2. | |
| CLASSIFICATION | AWS | A 5.5: E 10018-D2 CSA W48 E 6918-D2 |
| | EN ISO | 18275-A: E 62 4 MnMo B 42 H5 |
| | DIN | 8529: EY 62 75 Mn1 MoB |
| SUITABLE FOR | Designed for welding steels with yield strength >600N/mm ² in offshore as S550QL1, OPTIM 500ML, API: X70, X80, PAS 65 us, PAS 70 us, Dilimax 500, Dilimax 550, AISI 4130, 4140, 8630 and ASTM grades A182 Grade F22. | |
| APPROVALS | DNV (4Y62), CE approved | |

WELDING POSITIONS:



ANALYSIS OF THE PURE WELD DEPOSIT

| C | Mn | Si | P | S | Mo |
|------|------|------|-------|-------|------|
| 0.09 | 1.90 | 0.50 | 0.025 | 0.020 | 0.40 |

MECHANICAL PROPERTIES

| Heat treatment | R _{P0,2} (N/mm ²) | R _m (N/mm ²) | A ₅ (%) | Impact energy (J) ISO-V | | | Hardness HRc / HV |
|----------------|---|--|-----------------------|-------------------------|-------|------|----------------------|
| | | | | -20C | -40°C | -60C | |
| AW | >620 | 690-890 | >19 | | >70 | | |
| SR 620C / 1hr | 630-720 | 730-790 | 22-25 | | >55 | | |
| SR 630C / 12hr | 550-590 | 640-690 | 24-25 | | >47 | | |

AW: as welded / SR: stress relieved

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | | |
|--------------------|-------------|-------------|------------------|-------------------|--------------------|
| D (mm) | Length (mm) | Current (A) | kg / vacuum pack | pcs / vacuum pack | kg / master carton |
| 2.5 | 300 | 65-90 | 0,8 | 33 | 7,5 |
| 3.2 | 350 | 110-130 | 0,7 | 18 | 7,0 |
| 4.0 | 350 | 140-190 | 0,8 | 14 | 8,0 |

REDRYING TEMPERATURE 350°C / 2hr

NOTE Equivalent to welding wire ER 80S-D2