

## 10018-G

**CATEGORY** SMAW Stick Electrodes

**TYPE** Ultra low hydrogen high basic offshore electrode for high strength fine grain steels.

**APPLICATIONS** Designed for welding steels with tensile strength >690N/mm<sup>2</sup> in offshore, crane building, heavy transport, lifting etc.

**PROPERTIES** Mn, Ni, Cr and Mo alloyed basic electrode for welding low alloyed steels with tensile strength >690 N/mm<sup>2</sup>. Crack resistant and well suited for low-temperatures, ductility down to -60°C. Preheating, interpass temperature and post weld treatment as required for the base metal. **Hydrogen content:** < 3 ml / 100 g weld metal.

**CLASSIFICATION**

AWS	A 5.5: E 10018-G-H4
EN ISO	18275-A: E 62 6 Mn2NiCrMo B 42 H5
DIN	8529: EY 62 77 Mn2NiMo B H5

**SUITABLE FOR** S620, S550, Hardox, S620Q11, S600MC, Naxtra 63, TStE620, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, L480 - L550, X65 - X80, Hardox 400, XAR 400, Dilidur 400, 20MnCr65, 28CrMn43

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	P	S	Mo
0.05	1.30	0.35	0.35	2.0	<0.025	<0.025	0.33

**MECHANICAL PROPERTIES**

Heat treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>620	>690	>17	>110	>69	>47	
SR	>620	>690	>19		>32		

AW: as welded / SR: stress relieved (PWHT) 580°C/2hr

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / vacuum pack	pcs / vacuum pack	kg / master carton
2,5	350	70-90	0,8	36	8,0
3,2	350	90-125	0,7	18	7,0
4,0	350	120-160	0,8	14	8,0

**REDRYING TEMPERATURE** 400°C/1 hr