

12018-G

CATEGORY SMAW Stick Electrodes

TYPE Low hydrogen basic electrode for extra high strength steels

APPLICATIONS Designed for welding heat treated steels with yield strength upto 900 Mpa such as XABO 900, heavy lifting earth moving equipment etc.

PROPERTIES Basic electrode with excellent welding characteristics, recommended for welding fine grained similar alloyed high yield strength steel (< 900 Mpa) in case high impact values are required at sub zero temperatures. Hydrogen content (HD < 4 ml/100 g).

CLASSIFICATION

AWS	A 5.5: E 12018-G
EN ISO	18275-A: E 78 4 Mn2Ni1CrMo B42 H5 18275-B: ~E 8316-N5CM3 H5
DIN	8529: EY 79 64 Mn2Ni1CrMoB H5

SUITABLE FOR XABO 90, W.Nr.: 1.8925, Domex 700 MC

APPROVALS CE approved

WELDING POSITIONS:



ALL WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.06	1.60	0.40	0.75	2.40	0.60

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>790	980-1080	>14		>47		

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	65-95	2	12	17.7
3.2	350	90-140	2	12	34.7
4.0	350	140-190	2	12	67.6

REDRYING TEMPERATURE 400°C / 1hr