

## 12018-Mo

**CATEGORY** SMAW Stick Electrodes

**TYPE** Low hydrogen basic electrode for extreme high strenght steels

**APPLICATIONS** Designed for welding heat treated steels with yield strength >960 Mpa such as S960QL and TsTE960V in crane building, heavy lifting earth moving equipment etc.

**PROPERTIES** Basic electrode with excellent welding characteristics, recommended for welding fine grained similar alloyed high yield strength steel (> 960 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 89 4 ZB62 H5
DIN	8529: EY 89 75 Mn2Ni1CrMoB H5

**SUITABLE FOR** S960QL, TSTE 960V, Xabo 90, X96, Weldox 900 Weldox 1100, Domex 960, Domex Wear 360, XABO 90, StE890V, StE960TM, weldox 900, StE 890, S890QL1, A517, X120, StE 960, S960QL1, S1100 (till 12 mm)

**APPROVALS** CE approved

**WELDING POSITIONS:**



**PURE WELD DEPOSIT**

C	Mn	Si	Cr	Ni	Mo
0.07	1.65	0.50	0.90	2.60	0.85

**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	>900	>1050	>15		>47		

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	65-95	2.4	14.4	17.7
3.2	350	90-140	2.7	16.2	34.7
4.0	350	140-190	3.8	22.8	67.6

**REDRYING TEMPERATURE** 300-350°C / 2hr