

9018-G

CATEGORY SMAW Stick Electrodes

TYPE Ultra low hydrogen high basic offshore elektrode

APPLICATIONS Crane, heavy transport, platforms, vessel and lifting equipment in offshore, pipeline, riser and applications that require NACE requirements (less than 1% Nickel).

PROPERTIES High basic offshore electrode according the latest offshore requirements for sub zero temperatures down to -60°C. Suitable for steel types upto 550 N/mm² yield strength, excellent welding properties and extreme low hydrogen content below 3 ml/100gr weld metal. The weldmetal is suitable for longer post weld heat treatments as applied in Riser applications.

CLASSIFICATION

AWS	A 5.5: E 9018-G-H4R
EN ISO	2560-A: E 55 6 Mn 1NiMoB42 H5
DIN	8529: EY 55 76Mn1NiMoB H5

SUITABLE FOR S460, S500, S550, SSt52, St70.2, , StE500 to StE500, TStE 500, 17MnMoV64, 15CuMoNb5, 11NiMoV53, 20MnMoNi45, Oceanfit 60, Oceanfit 65, Oceanfit 420, Oceanfit 460, 4130, 4140, X80, X90

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %

C	Si	Mn	Ni	Mo	P	S
0.06	0.40	1.60	1.0	0.30	<0.025	<0.025

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				+20C	-40°C	-60C	
AW	>550	630-780	>21	>150		>55	
SR	>550	>610	>21			>55	

AW: as welded, SR: PWHT 610°C / 2hr

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / metal can	pcs / metal can	kg / 6 pack
2,5	350	65-95	2,5	107	15
3,2	350	90-140	2.6	66	15.6
4,0	450	140-185	3.3	48	19.8
5.0	450	180-240	3.6	34	21.6

REDRYING TEMPERATURE 400°C/1hr