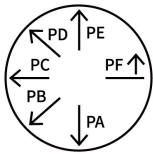


S-8018.G

Classification

AWS A5.5/ASME SFA-5.5 E8018-G
JIS Z 3211 E5518
EN ISO 2560-A E46 2 B 3 2
KS D7006 E5316

Welding Positions



Features

- Good bead appearance
- Good crack resistance
- Good X-ray performance
- Good mechanical properties
- Iron powder and low hydrogen type electrode (high efficiency)

Polarity

AC or DC +

Application Areas

- Heavy steel fabrication
- Shipbuilding
- Offshore structure

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.10	0.37	1.71	0.012	0.008

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
562(81)	666(97)	24	0(32) -30(-20)	127(94) 103(76)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	60-90	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	90-140	80-120	
4.0(5/32)	400(16)	130-190	120-170	
5.0(3/16)	400(16)	180~240	150-200	
6.0(15/64)	450(18)	250-300	-	

SAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux