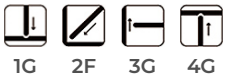
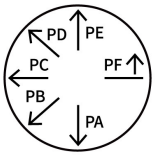
S-8018.GH

Classification

AWS A5.5/ASME SFA-5.5 E8018-G
JIS Z 3211 E5518
EN ISO 2560-A E50 4 ZMo B 4 2 H5

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

350~400°C (662~752°F) X 0.5~1hr

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

C	Si	Mn	P	S	Mo
0.04	0.30	1.45	0.011	0.005	0.35

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
580(84)	640(93)	30	-20(0) -40(-40)	116(86) 85(63)

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	