

Stick electrode

Features: ■ Suitable for 550 to 610MPa tensile strength steel

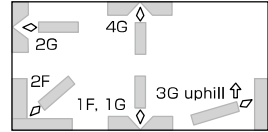
Classification: AWS A5.5 E9018-G

Redrying Conditions: 350~400°Cx1h

Identification color: 1st Pink, 2nd Yellow

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	34	170W, 120H, 380L
4.0	400	5	20	61	170W, 120H, 430L
5.0	450	5	20	93	170W, 110H, 480L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.06	0.09
Si	0.68	0.40~0.75
Mn	1.21	0.80~1.40
P	0.01	0.03
S	<0.01	0.03
Ni	0.59	0.45~0.80
Mo	0.26	0.20~0.35

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	80~120
4.0	135~185	110~170
5.0	190~250	150~200

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	570	531min.
TS (MPa)	660	621min.
El on 4d (%)	29	17min.
IV -20°C (J)	170	27min.