

## Stick electrode

**Features:**

- Good impact values down to -60°C
- Excellent crack resistibility

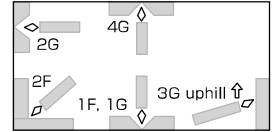
**Classification:** AWS A5.5 E11018-G H4

**Redrying Conditions:** 350~400°Cx1h

**Identification color:** 1st Brown, 2nd Brown

**Polarity:** DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 90H, 330L
3.2	350	5	20	32	170W, 120H, 380L
4.0	400	5	20	57	170W, 110H, 430L
5.0	400	5	20	90	170W, 120H, 430L

## Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.04	0.09
<b>Si</b>	0.60	0.20~0.75
<b>Mn</b>	1.49	1.20~1.90
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	2.92	2.50~3.30
<b>Mo</b>	0.77	0.40~1.00

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	70~100	65~95
3.2	80~120	70~110
4.0	120~160	90~150
5.0	170~210	-

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	770	669min.
<b>TS (MPa)</b>	830	759min.
<b>El on 4d (%)</b>	24	15min.
<b>IV -60°C (J)</b>	100	47min.

## Approvals

<b>ABS</b>	5YQ690 H5
<b>LR</b>	5Y69m H5
<b>DNV-GL</b>	5Y69 H5
<b>BV</b>	5Y69 H5
<b>CCS</b>	5Y69 H5

Note: DCEP only