

## Stick electrode

- Features:**
- Suitable for butt and fillet welding of heavy structure
  - Good performance by DCEP current

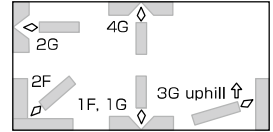
**Classification:** AWS A5.5 E8018-G

**Redrying Conditions:** 350~400°Cx1h

**Identification color:** -

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	24	170W, 105H, 380L
3.2	400	5	20	41	170W, 105H, 430L
4.0	450	5	20	69	170W, 105H, 480L

## Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.15
<b>Si</b>	0.34	0.75
<b>Mn</b>	1.74	1.40~2.25
<b>P</b>	0.012	0.030
<b>S</b>	0.007	0.030

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

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	65~95	60~90
3.2	90~130	80~120
4.0	130~190	110~170

## All-weld mechanical properties

	Typical (DCEP)	Guaranty
<b>0.2%YS (MPa)</b>	540	462min.
<b>TS (MPa)</b>	615	552min.
<b>EI on 4d (%)</b>	30	19min.
<b>IV -40°C (J)</b>	150	32min.

## Approvals

<b>ABS</b>	3YQ460 H10, MG
<b>LR</b>	3Y46m, H10
<b>DNV-GL</b>	3Y46 H10, MG
<b>BV</b>	3Y46H10 UP