

S-8018.C1

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E8018-C1

JIS Z3211 E5518-N5 AP L

EN ISO 2560-A-E46 5 2Ni B 3 2

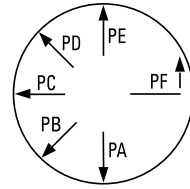
Applications

- Low temperature strength steel (2.5% Ni)
- Offshore structure

Features

- Good impact value at -60°C
- Iron powder and low hydrogen type electrode (high efficiency)

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.08	0.66	0.70	0.011	0.009	2.40

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)	Heat Treatment
518 (75,200)	593 (86,100)	30.2	-60 (-76)	78 (58)	605 (1121°F) X 1hr. S.R

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	400 (16)	400 (16)	450 (18)
F	90~130	130~180	190~240	250~300
V-up, OH	80~120	120~170	-	-