S-8018.G

Type : Basic

Conformances

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

JIS Z3211 E5518

EN ISO 2560-A-E46 2 1Ni B 3 2

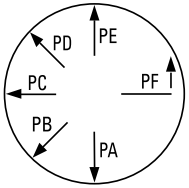
Applications

- Heavy steel fabrication
- Shipbuilding
- Offshore structure

Features

- Good bead appearance
- Good crack resistance
- Good X-ray performance
- Good mechanical properties
- 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	Length	Standard	
mm (in)	mm (in)	packet	carton
		5kg(11lbs)	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
0.07	0.61	1.29	0.016	0.012	0.83

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)
542 (78,700)	622 (90,300)	30.2	0 (32) -20 (-4)	147 (109) 103 (76)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	60~90	90~140	130~190	180~240	250~300
V-up, OH	50~80	80~120	120~170	150~200	-