

S-9018.M

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E9018-M
EN 757 - E50 4 B 4 2

SWAW

Applications

S-9018.M can be used for welding of high tensile weather proof steel used in pressure vessels, bridges, rolling stocks, machines.

Characteristics on Usage

S-9018.M is an iron powder low hydrogen type electrode which provides good workability in all positions.

The weld metal has a good crack resistibility because of less hydrogen contents.

X-ray performance and usability are good.

Notes on Usage

- ① Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ② Adopt back step method or strike the arc on a small plate prepared for this particular purpose because arc striking on base metal is in danger of initiating cracking.
- ③ Preheat at 80~100°C(172~212°F). The temperature to be applied varies in accordance with plate thickness and kind of steel.

Welding Position

Current



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.05	0.46	1.21	0.017	0.011	1.47	0.22

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)
585 (85,000)	646 (93,800)	27.6	-50 (-58)	89 (66)

Approval

I Packing

ABS

Packet 5 kg (11 lbs)

Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size 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	70~100	90~140	130~190	180~240	250~300
V-up, OH	60~80	80~120	120~170	150~200	-