

Applications

S-8018.C1 can be used for welding of 2.5%Ni and 3.5%Ni steel used in machinery for low temperature.

Characteristics on Usage

S-8018.C1 is an iron powder low hydrogen type electrode. Its coating contains much iron powder, which increasing working efficiency. The deposit is extremely dense and the good mechanical properties make this electrode particularly suitable for weldments to withstand impact at subnormal temperatures.

Notes on Usage

- ① Dry the electrodes at 350~400 °C(662~752°F) for 60 minutes before use.
- ② Preheat at 80~100°C(176~212°F).
- ③ Keep the arc as short as possible.

Welding Position



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

Current

AC or DC +

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°C(1121°F) X 1hr. S.R

Approval

I Packing

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

Sizes Available and Recommended Currents (Amp.)

Size 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	-	-