

## CLASSIFICATION

EN ISO 3580 : E Mo B 22  
AWS A5.5: E 9018-D1

## GENERAL DESCRIPTION

L-9018-D1 is a basic coated, AC/DC electrode for the welding of high tensile strength steels. It gives a weld metal that has good notch toughness down to -60°C. Grain boundary cracking risk is very low.

## APPROVALS

GOST, SEPRO, TSE

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Mo
0.06	0.40	1.30	0.40

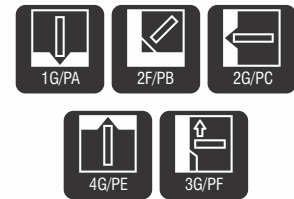
## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 580 N/mm <sup>2</sup>
Tensile Strength	: 660 N/mm <sup>2</sup>
Elongation (L=5d)	: 24 %
Impact (ISO-V)	: 170 J (+20°C)
	50 J (-50°C)
	40 J (-60°C)

## WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
3.25	350	110 - 140	3790	4.6 / 120	5
4.00	450	150 - 190	7300	5.8 / 80	6
5.00	450	190 - 250	10500	6.3 / 60	6



## APPLICATIONS AND MATERIALS TO BE WELDED

Due to the weld metal's good notch toughness proper ties down to -60°C, it is used for welding unalloyed and low alloyed steel structures exposing to low temperatures like LPG holders. Welding of low alloyed high tensile steels when preheating cannot be applied and enclosed joint welding and cladding of rails when a hardness of about 250 HV is required are among its application areas.

	DIN	EN
<b>General Structural Steels</b>	St 50-2, St 60-2, St 70-2	E295, E335, E360
<b>Fine Grained Steels</b>	StE 380 - StE 500 WStE 380 - WStE 500	S380N - S500N P380NH - P500NH
<b>Pipe Materials</b>	X42, X46, X52, X56, X60, X65 (API 5LX)	-
<b>Low Temperature Steels</b>	TTSt 35 N, TTSt 35 V	-

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.