

CLASSIFICATION

EN ISO 18275 : E 55 6 1NiMo B 42
AWS A5.5: E9018-G

GENERAL DESCRIPTION

L-9018 is a basic electrode. It is used for the welding fine-grained and high strength steels with a yield strength min. 600 N/mm². It gives a weld metal that has a high toughness value and resistant to cracking at low temperatures down to -60°C. It has 120 % metal recovery.

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

C	Si	Mn	Ni	Mo
0.04	0.30	1.00	1.10	0.35

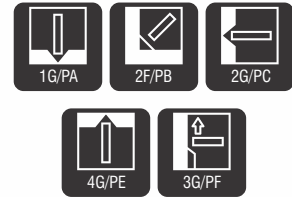
MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 600 N/mm ²
Tensile Strength	: 650 N/mm ²
Elongation (L=5d)	: 23 %
Impact (ISO-V)	: 160 J (-30°C) 70 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]
2.50	350	80 - 120	2320	4.6 / 200	5
3.25	350	110 - 140	3710	5.0 / 135	5
4.00	450	140 - 190	7470	6.7 / 90	6



MATERIALS TO BE WELDED

	DIN	EN
Fine Grained Steels	StE 420 - StE 500 WStE 420 - WStE 500 TStE 420 - TStE 500	S420N - S500N P420NH - P500NH S420NL - S500NL / P275NL1 - P460NL1
Pipe Materials	X60, X65, X70, X75, X80 (API 5LX)	-

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.