

## 12018-G

**CATEGORY** SMAW Stick Electrodes

**TYPE** Low hydrogen basic electrode for extra high strength steels

**APPLICATIONS** Designed for welding heat treated steels with yield strength upto 900 Mpa such as XABO 900, heavy lifting earth moving equipment etc.

**PROPERTIES** Basic electrode with excellent welding characteristics, recommended for welding fine grained similar alloyed high yield strength steel (< 900 Mpa) in case high impact values are required at sub zero temperatures. Hydrogen content (HD < 4 ml/100 g).

**CLASSIFICATION**

AWS	A 5.5: E 12018-G
EN ISO	18275-A: E 78 4 Mn2Ni1CrMo B42 H5 18275-B: ~E 8316-N5CM3 H5
DIN	8529: EY 79 64 Mn2Ni1CrMoB H5

**SUITABLE FOR** XABO 90, W.Nr.: 1.8925, Domex 700 MC

**APPROVALS** CE approved

**WELDING POSITIONS:**



**ALL WELD DEPOSIT WEIGHT %**

C	Mn	Si	Cr	Ni	Mo
0.06	1.60	0.40	0.75	2.40	0.60

**MECHANICAL PROPERTIES**

Heat treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	>790	980-1080	>14		>47		

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	65-95	2	12	17.7
3.2	350	90-140	2	12	34.7
4.0	350	140-190	2	12	67.6

**REDRYING TEMPERATURE** 400°C / 1hr