

## 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

D (mm)	Welding Parameters		Packing		
	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