SPARK 8018 G

Medium tensile low-hydrogen electrode for steel structures under dynamic loads

Classification: AWS A5.1: E 8018 G

Description:

A heavy coated basic - iron powder type hydrogen controlled electrode with excellent welding performance. The electrodes yield a stable arc with low spatter produce weld deposits with high crack resistance. Weld deposit is of high radiographic quality. Suitable for welding higher tensile fine grained steels in all positions.

Applications:

Suitable for steel structures working under dynamic load. Joining and building-up of low carbon and medium tensile steels with sub-zero temperature impact requirement down to - 50 deg. C. Applications include storage tanks, pressure vessels, pipes, bridges, earth moving machinery, ship-building etc.

Current Condition: DC ± AC

Welding Parameters:

Size (mm X mm)	Current (Amps)
2.50 x 350	75 - 110
3.15 x 450	100 - 140
4.00 x 450	140 - 190
5.00 x 450	190 - 270

Typical Mechanical Properties:

UTS	570 N/mm^2
Elongation	25 %
YS	480 N/mm^2
CVN at – 50 C	50 J

Typical All weld metal composition (%):

C	Mn	Si	S	P	Ni
0.06	1.20	0.28	0.014	0.018	0.9