

# S-11018.M

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E11018-M  
EN 757 - E62 4 B 4 2

## Applications

S-11018.M can be used for welding of low alloyed high strength steels such as HY-80, HY-90 and HY-100.

## Characteristics on Usage

S-11018.M is a low alloy, low hydrogen iron powder type electrode displaying fast, efficient metal transfer. The all-weld metal has a good X-ray performance and excellent tensile strength and impact properties.

Deposition rates are higher than E11016-G electrode types.

## Notes on Usage

- ① Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ② Preheat at 200~300°C(392~572°F).
- ③ Keep the arc as short as possible.

## Welding Position



1G (PA)    2F (PB)    3G (PF)    4G (PE)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo
0.07	0.48	1.62	0.023	0.012	2.04	0.21	0.35

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
722 (104,900)	796 (115,600)	21.6	-50 (-58)	50 (37)

## Approval

ABS

## Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55~90	90~130	130~190	190~240	250~300
V-up, OH	50~80	80~120	120~170	150~200	-