S-8018.C3

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E8018-C3

JIS Z3211 E5518-N2

EN ISO 2560-A-E46 4 1Ni B 3 2

ABS AWS A5.5 E8018-C3

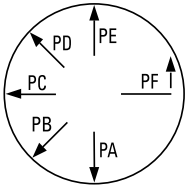
Applications

- Low temperature strength steel (1% Ni)
- Offshore structure

Features

- Good impact value at -40°C
- Iron powder and low hydrogen type electrode (high efficiency)

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter	Length	Standard	
mm (in)	mm (in)	packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	√	
3.2 (1/8)	350 (14)	√	
4.0 (5/32)	400 (16)	√	
5.0 (3/16)	400 (16)	√	
6.0 (15/64)	450 (18)	√	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.07	0.59	1.00	0.020	0.009	0.94

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
540 (78,400)	619 (89,900)	30.8	-40 (-40)	76 (56)

Typical Welding Parameters / Amp.(A)

Diameter 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	-	-