

AK E11018-G

Description: AK-E10018-G is a low-alloy steel electrode with low-hydrogen sodium type coating, which adopts DC reverse connection. All-position welding possible with good mechanical properties and crack resistance.

Application: For welding of low alloy steels of corresponding strength classes.

Typical Chemical Composition(%):

	C	Si	Mn	Ni	V	Cr	Mo		
Requirement	0.10	0.60	1.30-1.80	1.25-2.5	0.05	0.40	0.25-0.50	---	---
Actual Result	0.061	0.23	1.38	2.38	0.01	0.36	0.45	---	---

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥780	≥ 690	≥ 15	≥27J(-50℃)
Actual Result	850	730	20	80

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current / A	F/ H	60-80	90-130	140-180
	V/OH	50-70	80-110	130-170