

AK E9018-G

Description: AK-E9018-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	S	P	Ni	Mo	Cr	V
Requirement	0.12	0.80	0.6-1.95	0.03	0.03	0.80-1.80	0.50	0.20	0.05
Actual Result	0.08	0.40	1.40	0.015	0.020	1.3	0.03	0.12	0.01

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥620	≥ 530	≥ 17	≥47J(-40℃)
Actual Result	720	600	24	80

Recommended welding parameters:

Diameter/ mm		3.2	4.0	5.0
Welding current / A	F/ H	90-130	140-180	190-230
	V/OH	80-110	130-170	180-210