

## Pipeweld 8018

Pipeweld 8018 is an electrode specifically designed for welding high tensile low alloyed pipe steels grades API 5L X60, X65 & X70.. Excellent welding performance , suitable for positional welding of root pass as well as fill and cap. Good impact properties to -40.

### Specifications

<b>Classifications</b>	SFA/AWS A5.5 : E8018-G EN ISO 2560-A : E 50 4 Z B 42 H5
<b>Approvals</b>	NAKS/HAKC : 3.2 mm

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+(-)
<b>Diffusible Hydrogen</b>	<5.0ml/100g
<b>Alloy Type</b>	0.5% Mo
<b>Coating Type</b>	Lime Basic

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	540 MPa	630 MPa	26 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	-40 °C	80 J

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.06	1.41	0.33	0.03	0.02	0.37

### Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	80-140 A	23 V	61 %	91 sec	1.6 kg/h