

Pipeweld 10018

Pipeweld 10018 is a high strength all positional electrode for pipe applications. This electrode can be used on X80 (strain based) and X100.

Specifications	
Classifications	SFA/AWS A5.5 : E10018-G EN ISO 18275-A : E 62 4 Mn1NiMo B 32 H5

Welding Current	DC+, AC
Diffusible Hydrogen	< 5.0 ml/100g
Coating Type	Lime Basic

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	630 MPa	720 MPa	25 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	75 J

Typical Weld Metal Analysis %					
C	Mn	Si	Ni	Cr	Mo
0.06	1.70	0.44	0.75	0.05	0.36

Deposition Data						
Diameter	Amps	Volts	Efficiency (Per)	Number of electrodes/kg weld metal	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	65-105 A	21.4 V	67 %	76	55.4 sec	0.86 kg/h
3.2 x 350.0 mm	80-140 A	24 V	59 %	50	63 sec	1.14 kg/h
3.2 x 450.0 mm	80-145 A	22 V	65 %	35	85.6 sec	1.2 kg/h
4.0 x 350.0 mm	95-200 A	22 V	64 %	30	74.1 sec	1.6 kg/h
4.0 x 450.0 mm	95-200 A	22 V	68 %	22	88.8 sec	1.8 kg/h