

Inweld 11018M

AWS A5.5 E11018M

Chemical Composition of Inweld 11018M

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.10	0.40	1.25- 2.50	0.25- 0.50	1.30- 1.80	0.60	0.03	0.03	---	---

Single values are maximum unless otherwise specified.

Description and Applications

Designed for welding quenched and tempered steels such as HY-80, HY-100, T-1, and SSS. Produces high strength weld deposits with excellent low temperature impact properties (44 ft-lbs @-60°F). X-ray quality welds with great crack resistance. Tensile strengths of up to 112,000 psi. Applications include steel plates in military applications, low alloy castings, forgings, quenched and tempered steels in structural work and pressure vessels.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	110,000 psi
Yield Strength:	98,000 psi
Elongation:	20%

Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"		70-110
1/8"		90-160
5/32"		130-210
3/16"		180-300

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