

Inweld 9018M

AWS A5.5 E9018M

Chemical Composition of Inweld 9018M

| Fe | C | Cr | Ni | Mo | Mn | Si | P | S | N | Cu |
|---------|------|------|---------------|------|---------------|------|------|------|-----|-----|
| Balance | 0.10 | 0.15 | 1.40- 1.80 | 0.35 | 0.60- 1.25 | 0.80 | 0.03 | 0.03 | --- | --- |

Single values are maximum unless otherwise specified.

Description and Applications

Low hydrogen, low alloy, all-position electrode for applications requiring good notch toughness at low temperatures and a tensile strength in the 90,000 psi range. For welding quenched and tempered steels such as T1, HY80 and HY90. For joining base metals ASTM A225 Gr. B, A235 Gr. G A288 Class 2, A291 Class 1 and 2. Typical applications include pressure vessels, bridges, machinery, vehicles, offshore constructions and penstocks. Weld deposits exhibit excellent impact properties and x-ray quality.

Typical Weld Metal Properties

| | <u>AWS Spec</u> |
|-------------------|-----------------|
| Tensile Strength: | 90,000 psi |
| Yield Strength: | 77,000 psi |
| Elongation: | 17% |

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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