

9018- M PARA ARCO (C.A.C.C.)

SPECIAL ELECTRODE WITH A LOW HYDROGEN CONTENT AND POWDER IRON COVERING. ITS FILLER METAL IS A LOW NICKEL-CHROMIUM-MOLYBDENUM ALLOY WITH HIGH MECHANICAL RESISTANCE.

CLASSIFICATION A.W.S: E 9018-M

IDENTIFICATION: GREY COATING

APPLICATIONS: It is recommended for the production of equipment and machinery to be submitted to heavy duty operation at low temperatures. It is also used to join heat treated steel (annealed and hardened). 9018 M electrodes are recommended for the following kinds of steel (ASTM specifications).

A 148-73 Gr. 90-60 oooooA 291 - 64 Gr. 2

A 202 - 74 Gr. ooooooooooA and B A 372-74 Gr. 3

A 225- 56 Gr ooooooooooA and B A 486-74 Gr. 90

A 236 -74Gr.F and G. oooo A 521 - 74 Gr. AC and AD

A 238 - 74Gr. F and G ooooA 615-74 Gr. 60

CHARACTERISTICS AND PROCEDURE: This electrode retains its properties at low temperatures (as low as - 60 ° C). It can be used in all positions. The resulting weld seams have no cavities and only minimal splatter; they are smooth and achieve excellent penetration.

TENSILE RESISTANCE:	6,820 KG./CM2 (97,000 PSI)
ELASTIC LIMIT:	5,975 KG./CM2 (85000 PSI)
ELONGATION IN 5 cm:	28%
CHARPY V:	2.7 KG X M (- 51°C)
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	Si	Ni	Mo	3.25 mm - 1/8"	100-130
0.05	1.10	0.32	1.70	0.28	4.0 mm - 5/32"	140-180
					5.0 mm - 3/16"	200-250