



M-90 E7018

FEATURES

- *SUITABLE FOR BUTT AND FILLET WELDING OF HEAVY STRUCTURE
- *GOOD CRACK RESISTANCE AND X-RAY PERFORMANCE
- *GOOD MECHANICAL PROPERTIES
- *IRON POWDER AND LOW HYDROGEN TYPE ELECTRODE (HIGH EFFICIENCY)

APPLICATION

- *PRESSURE VESSEL
- *HEAVY STEEL FABRICATION
- *SHIPBUILDING

CLASSIFICATION

- *AWS/A5.1/ASME SFA5.1 E7018

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.06	0.5	1.2	0.017	0.011			

MECHANICAL PROPERTIES

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2)	N/mm2 (lbs/in 2)	(%)	oC (oF)	J (ft lbs)
504 (73,200)	572 (83,100)	29.8	-30(-22)	111(82)

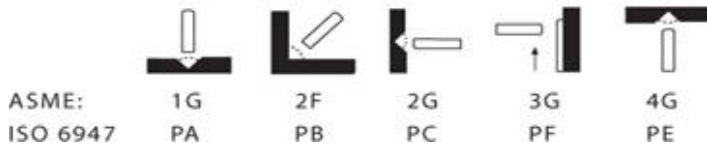
WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2	4
LENGTH (mm)	350	350	400
CURRENT (amps)	55-85	90-130	130-180

CURRENT

- *AC or DC +

WELDING POSITIONS



Current

= +	~	(U _o : 70 V)
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