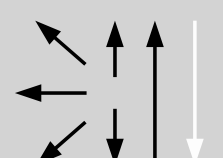


Classifications						
EN ISO 18275-A	AWS A5.5			AWS A5.5M		
E 89 4 Mn2Ni1CrMo B 4 2 H5	E12018-G (E12018M mod.)			E8318-G (E8318M mod.)		
Characteristics and typical fields of application						
<p>Basic covered NiCrMo alloyed electrode.            Low H<sub>2</sub>-content ≤5 ml/100 g (HD) in the weld metal. For high strength fine grained structural steels.            Suitable for bridge building, steel and crane construction; the weld metal is insensitive to cold cracking.</p>						
Base materials						
Quenched and tempered high strength fine grained structural steels, such as X-ABO 90 (S890QL)						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Cr	Mo	Ni
wt-%	0.08	0.40	1.45	0.80	0.50	2.20
Mechanical properties of all-weld metal						
Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-45 °C	
aw	880	920	18	90	47	
Operating data						
	<b>Polarity:</b> DC ( + )	<b>Redrying:</b> 300 – 350 °C / 2 h (572 – 662 °F)	<b>ø (mm)</b>	<b>L mm</b>	<b>Amps A</b>	
			3.2	350	90 – 140	
			4.0	450	140 – 190	
			5.0	450	170 – 240	
Approvals						
DB (10.132.46), CE						