

ESAB 118

ESAB 118 is a Cr-Ni-Mo alloyed low hydrogen electrode, for welding high strength low alloy steels including quenched and tempered steels. The electrode gives a tough weld metal without the risk of temper brittleness. The all position electrode has excellent arc and current carrying characteristics, with an easily removable slag and excellent bead finish contributing to its immense welder appeal. Used for components of penstock, earth moving equipment and other heavy steel fabrications made of high tensile strength steels.

Specifications

Classifications	SFA/AWS A5.5 : E11018M
Welding Current	AC, DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Cr-Ni-Mo alloyed
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	690 MPa	780 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-50 °C	50 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	1.40	0.40	2.20	0.15	0.40

Deposition Data

Diameter	Current
2.5 x 350.0 mm	75-110 A
3.15 x 450.0 mm	90-140 A
4.0 x 450.0 mm	140-190 A
5.0 x 450.0 mm	160-240 A