

# ES 8018-G

Type Lime-basic

SMAW

E8018-G

**ESWECO**  
*The Art of Welding*

## Description

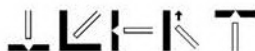
ES 8018-G is a NiCu-alloyed LMA electrode, which deposits a weld metal with good corrosion resistance to sea-water and flue gases, for the welding of weatherproof steel and for ship's hull structural steel. The weld metal has excellent mechanical properties. It is particularly suitable for welding the shell plating of ice-breakers and other ships, which work under conditions where the protective paint coating wears off.

## Recovery

125%

## Current

AC, DC(+) OCV 65 V



## Classifications

SFA/AWS A5.5	E8018-G
EN 499	E 46 5 Z B 32
ISO 2560	E 51 5 B 120 26 H

## Typical all weld metal composition, %

C	Si	Mn	Ni	Cu
0.06	0.4	1.0	0.7	0.4

## Typical mech. Properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	590
Elongation, %	27

## Charpy V

Test temps, °C	Impact values, J
-20	160
-40	130
-50	70

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	80-115	21
3.2	450	110-150	22
4.0	450	130-200	23
5.0	450	190-280	27