



S. R. Industries

STAR ARC E9018-M

E9018-M is an electrode used for welding higher strength steels when tensile strength in excess of 90 ksi is required. The coating on this electrode is specially formulated to resist moisture pick-up in conditions of high heat and humidity. It's resistance to moisture reabsorption also helps prevent hydrogen cracking and aids in elimination of starting porosity.

Typical Applications : joining HY-90, HY-80, T-1 and other high tensile steels

AWS Class: E9018-M H4R	Classification: AWS A5.5/A5.5M:2006
Alloy: E9018-M	ASME SFA A5.5
Welding Position: F, V, OH, H	Current: AC-DCEP
Tensile Strength, kpsi:	90
Yield Strength, kpsi:	78-90
Elongation %:	24

*For 3/32 electrodes, the upper value for the yield strength may be 5 kpsi higher

Typical Wire Chemistry as per AWS A5.5 (single values are maximum)

C	Mn	Si	P	S	Ni	Cr	Mo	V
0.10	0.60-1.25	0.80	0.030	0.030	1.40-1.80	0.15	0.35	0.05

Typical Welding Parameters			
Diameter		Process	Amps
in	(mm)		
3/32	(2.4)	SMAW	70-110
1/8	(3.2)	SMAW	90-160
5/32	(4.0)	SMAW	130-210
3/16	(4.8)	SMAW	180-300

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