



S. R. Industries

STAR ARC E11018M

E11018M is an outstanding electrode designed for use in Military applications which require weld joints with 116 ksi minimum tensile strength. This electrode provides excellent puddle control with good wetting action and tie in. E11018M offers good arc characteristics and easy slag removal.

Typical Applications : joining HY-80, HY-90, HY-100, and T-1 steels

AWS Class: E11018M	Classification: AWS A5.5/A5.5M:2006
Alloy: E11018M	ASME SFA A5.5
Welding Position: F, V, OH, H	Current: DCEP
Tensile Strength, kpsi:	100
Yield Strength, kpsi:	98-110*
Elongation in 2" (%):	20

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

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

C	Mn	P	S	Si	Cr	Mo	Ni	V
0.10	1.30-1.80	0.030	0.030	0.60	0.40	0.25-0.50	1.25-2.50	0.05

Typical Welding Parameters				
Diameter		Process	Amps (flat)	Amps (V/OH)
in	(mm)			
3/32	(2.4)	SMAW	55-85	50-80
1/8	(3.2)	SMAW	90-130	80-120
5/32	(4.0)	SMAW	140-190	110-150
3/16	(4.8)	SMAW	180-230	130-190

Address : C-617, DSIIDC, Narela, Delhi-110040 India

Tel : 011 47506585 **Mobile :** + 91 9911166585

E.Mail : srindus@yahoo.com

Website : www.stararc.in