



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

9018M Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

9018M is an all-position, low-hydrogen, iron-powder electrode containing manganese, molybdenum and nickel. 9018M is designed for welding low alloy, high tensile, quenched and tempered steels such as T1, HY80 and HY90. Weld deposits have excellent impact properties and are X-ray quality.

PREHEATING AND POSTHEATING Depending upon the thickness and hardening characteristics of the work piece, preheating at a temperature between 140-220° F is recommended.

TYPICAL APPLICATIONS 9018M is commonly used to make attachment welds on steels in the 90,000 psi tensile strength range. Typical applications would involve pressure vessels, bridges, machinery and penstocks. Base metals would include ASTM A225 Gr. B, A235 Gr. G, A288 class 2, A291 class 1, 2 and many others.

TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps (Flat)	Amps (Vertical & Overhead)
3/32"	55-100	50-80
1/8"	90-150	60-120
5/32"	140-210	110-150
3/16"	180-270	130-190
1/4"	250-350	

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

Carbon	0.07		
Manganese	1.10	Elongation in 2"(%)	30%
Silicon	0.51	Yield Strength (psi)	83,000
Molybdenum	0.20	Tensile Strength (psi)	97,000
Nickel	1.58	Charpy V-notch at -60°F	65 ft-lbs

AVAILABLE SIZES: TE 9018M = 3/32", 1/8", 5/32", 3/16"
Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.5 E9018M
ASME SFA 5.5 E9018M

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