



# USA 8018W Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)

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



## ALLOY DESCRIPTION AND APPLICATION;

USA 8018W electrodes are designed specifically for welding the low-alloy, high-strength "weathering" steels where corrosion resistance, toughness as well as good creep resistance properties found with base metals such as ASTM A588, A242, Cor-ten, and Mayari R®. The uniform color blend of weld deposit with "weathered" steel makes these electrodes an excellent choice when architectural appearance is important.

## TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps (Flat)	Volts	Diameter	Amps (Flat)	Volts
1/16"	35-65	20-25	5/32"	130-200	25-31
5/64"	45-70	21-25	3/16"	200-240	25-31
3/32"	60-100	23-27	7/32"	210-270	25-33
1/8"	90-150	24-28	1/4"	250-340	25-35

Use a short arc – dragging with 10-15% from 90°

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

## TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES (AWS values are maximum)

	AWS Spec.		AWS Spec.
Carbon	0.12 max	Nickel	0.40-0.80
Manganese	0.50-1.30	Copper	0.30-0.75
Silicon	0.35-0.80	Tensile Strength (ksi)	80 min.
Phosphorus	0.03 max	Yield Strength (ksi)	67 min.
Sulphur	0.03 max	Elongation in 2" (%)	19%
Chromium	0.45- 0.70	Charpy V-notch at 0°F	20 ft·lbs min.

**AVAILABLE SIZES:** TE 8018W = 1/8

**SPECIFICATIONS;** ANSI/AWS A5.5 E8018- W2  
ASME SFA 5.5 E8018- W2

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