



## COATED ELECTRODE LOW ALLOY STEEL

### ESSEN MS 1018 MB

Classificações: **AWS A5.5:2014 E10018-M ASME SFA5.5 E10018-M**  
E10018-M - Electrode with basic coating.

Low hydrogen electrode originally designed for military applications, such as welding HY80 and HY100 steels. To achieve the desired weld metal properties, this electrode has small alloy additions, especially Nickel. Suitable for joining high-strength, low-alloy or micro-alloyed steels of the same weld composition or low-strength steels, including carbon steel. Complies with Military Standard.

#### ALLOY TYPE:

C	Mn	Si	P	S	Ni	Mo	Cr
0,10% Máx.	0,75 a 1,70%	0,60% Máx.	0,030% Máx.	0,030% Máx.	1,40 a 2,10%	0,25 a 0,45%	0,35% Máx.

#### MECHANICAL PROPERTIES:

TENSILE STRENGTH:	YIELD STRENGTH:	ELONGATION:	IMPACT RESISTANCE:
690 MPa (Min.)	610 MPa (Min.)	20 % (Min.)	27J at- 50°C (Min.)

<b>WELDING CURRENT:</b>	CC+; CA
<b>COATING TYPE:</b>	BÁSICO



Flat



Horizontal



Vertical



Overhead

#### PRODUCT CHARACTERISTICS:

DIAMETER (mm):	LENGTH (mm):	CURRENT (A):	PACKAGING (kg):
2,50	350	70 a 95	5,00
3,25	350	100 a 130	5,00
4,00	450	140 a 170	5,00
5,00	450	180 a 220	5,00

#### CUSTOMER SERVICE POLICY

The above information is for reference purposes only and should not be considered as a warranty or certificate. Many variables can influence the results of a welding operation. Uniweld Industria de Eletrodos LTDA is not responsible for any incorrect application of the product. We recommend that if you have any questions, you contact our Technical Assistance department for proper support.