



MAC TRODE E61118-G

■ **Description & Applications:**

Superior low hydrogen electrode, Ni Cr Mo type AWS E11018-G. These electrodes must not be used if the electrodes have become damp before being re-dried (moisture will cause weld metal cracking)*. Smooth arc low spatter easy strike and restrike. When requirements are specified for high strength steels in specific sub zero toughness such as in the North Sea offshore and submarine fabrication work the electrode offers excellent properties. Materials to be welded RQT 701 HY 100 Navy Q2N OS690 cast steel.

* **NOTE :**

If the electrodes have become damp then immediately before use the electrode should be re-dried at 150°C for 1 hour (permitted moisture level is 0.10 max.)

■ **Related Specification:**

AWS E11018-G

■ **Typical All Weld Metal Chemical Analysis %:**

C	Mn	Si	S	P	Ni	Mo	Cr
0.051	1.11	0.42	0.012	0.010	2.14	0.49	0.41

■ **Typical All Weld Metal Mechanical Properties:**

As Welded

Tensile Strength	N/mm ²	850
0.2% Proof Stress	N/mm ²	800
Elongation on 4d	%	22
Reduction of Area	%	70
Impact Energy-50°C	Joules	90

■ **Current:**

AC/DC DC electrode positive (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-100	90-130	130-180	160-220	250-300

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.