



## MAC TRODE E6818-G

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### ■ **Description & Applications:**

A low hydrogen, basic flux coated, low alloy electrode. Using a silicon free, low nitrogen core wire. Suitable for welding all grades of structural steels with a specified minimum yield strength of 460 N/mm<sup>2</sup>. However, it is of special value when the steel/weld metal also needs guaranteed toughness properties at -50°C. Those steels include BS4360 all grades at 50F. All grades 'plates' to BS1501-225 and all grades 'forgings' to BS1501-224

### ■ **Related Specification:**

AWS E8018-G

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

C	Si	Mn	P	S	Ni	Fe
0.08	0.30	1.50	0.015	0.009	0.85	BAL

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

<u>As Welded</u>	<u>Typical</u>
Tensile Strength	580 N/mm <sup>2</sup>
0.2% Proof Stress	480 N/mm <sup>2</sup>
Elongation on 4d	26 %
Reduction of area	75 %
Impact Energy -50°C	80 Joules

### ■ **Current:**

DC +/- AC (OCV 70) Min

### ■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-90	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.