



## MAC TRODE E6918-G

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### ■ **Description & Applications:**

This is a low hydrogen electrode using a free, low nitrogen, high purity C:Mn core wire with a concentrically extruded, moisture resistant chemically basic flux with a controlled iron powder addition. It is an easy to use electrode for welding in all positions. Good restriking ability and smooth, easy flowing welds. Pre-heat & interpass temperatures 100°C min. and up to 200°C for thick sections.

### ■ **Related Specification:**

AWS E9018-G

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

C	Mn	Cr	Ni	P	S	Si	Mo
0.038	1.05	0.1	0.7	0.001	0.002	0.15	0.28

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

#### **As Welded**

Tensile Strength	N/mm <sup>2</sup>	620
0.2% Proof Stress	N/mm <sup>2</sup>	700
Elongation on 4d	%	26
Reduction of area	%	65
Impact Energy -10°C	Joules	80

### ■ **Current:**

AC/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.