

E9018-D1

Low Alloy Steel ■ AWS E9018-D1

KEY FEATURES

- Moisture resistant coating provides low amount of weld metal hydrogen levels for a superior weld
- Developed to resist sulphide-induced stress corrosion cracking
- Improved sub-zero toughness

WELDING POSITIONS

All, except vertical down

CONFORMANCES

AWS 5.5	E9018-D1
BS 2493	MnMoBH

TYPICAL APPLICATIONS

- Offshore Oil Pipework
- Fittings

DIAMETERS / PACKAGING

Diameter mm (in)	Length mm (in)	12.0 kg (26 lb) Carton	13.8 kg (30 lb) Carton	15.9 kg (35 lb) Carton	16.8 kg (37 lb) Carton
2.5 (3/32)	350 (13.78)	E9018D1-25	E9018D1-32	E9018D1-40	E9018D1-50
3.2 (1/8)	380 (14.96)				
4.0 (5/32)	450 (17.72)				
5.0 (3/16)	450 (17.72)				

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.5

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf)		Hardness HV
				@-30°C (-22°F)	@-50°C (-58°F)	
Requirements AWS E9018-D1	550 (80) min	630 (91) min	17 min	47 min	30 min	-
Typical Performance⁽³⁾ As-Welded	605 (88)	670 (97)	25	90	55	210

DEPOSIT COMPOSITION⁽¹⁾ – As Required per AWS A5.5

	%C	%Mn	%Si	%S	%P
Requirements AWS E9018-D1	0.10 max	1.25-1.75	0.80 max	0.025 max	0.025 max
Typical Performance⁽³⁾	0.07	1.5	0.4	0.01	0.015
	%Cr	%Ni	%Mo	%Cu	
Requirements AWS E9018-D1	-	-	0.25-0.45	-	
Typical Performance⁽³⁾	0.15	0.15	0.35	0.05	

TYPICAL OPERATING PROCEDURES

Polarity ⁽⁴⁾	Amperage			
	2.5 mm (3/32 in)	3.2 mm (1/8 in)	4.0 mm (5/32 in)	5.0 mm (3/16 in)
DC+	70-110	80-140	100-180	140-240

⁽¹⁾ Typical all weld metal ⁽²⁾ Measured with 0.2% offset ⁽³⁾ See test results disclaimer ⁽⁴⁾ Preferred polarity is listed first.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.