

SMAW Electrodes

- High Tensile & High Yield Strength Steel

GL108M1

AWS A5.5M E6918M / A5.5 E10018M
ISO 18275-A-E 55 5 Mn2NiMo B

Product Features:

- Iron powder low hydrogen type covered electrode for low alloy high yield and high tensile strength steel.
- Good arc stability, suitable for all positions.
- Good for RT examination, good mechanical properties.
- Low moisture absorption type covered flux to get good crack resistance.
- NAVSEA MIL-10018-M1.

Applications:

- Suitable for welding of 690 N/mm² grade low alloy steel or similar grade steels on pressure vessels and general steel structures.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Ni	Mo	Fe
0.05	0.40	1.33	0.04	2.04	0.41	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-50°C) J
658	691	27	63

Size (mm) & recommended welding parameters (A) DC+

Diameter / Length	3.2/350	4.0/400	5.0/450
Flat position	90~140	150~200	220~270
Vertical / overhead position	80~110	120~150	-

Note:

- 300~350°C x 1hr baking prior to use.

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