

MIDALLOY CHROMAX E10018-D2 H4R COATED ELECTRODE

CLASSIFICATION

- AWS 5.5 Class E10018-D2 H4R / ASME SFA 5.5 Class E10018-D2 H4R / ASME F-4, A-11

DESCRIPTION

- MIDALLOY E10018-D2 H4R is an AC/DC (Electrode Positive) Low Alloy Coated Electrode.

APPLICATIONS

- This coated electrode is designed for welding high tensile steels and manganese-molybdenum steels requiring tensile strengths of at least 100,000 PSI.
- Typical applications are manganese-molybdenum castings, alloy forgings, structural weldments, and pressure vessel applications, either as welded or stress-relieved conditions.

TYPICAL CHEMISTRY

C	Mn	Si	P	S	Cr	Mo
0.11	1.92	0.39	0.014	0.010	0.07	0.31

F#4, A#11

TYPICAL MECHANICAL PROPERTIES

STRESS RELIEVED 1 HOUR @ 1150°F

TENSILE STRENGTH	89,700 PSI
YIELD STRENGTH	77,400 PSI
% ELONGATION IN 2"	26%
CHARPY V-NOTCH @ -60°F	24 ft. lbs.

WELDING PARAMETERS

DIAMETER	3/32"	1/8"	5/32"	3/16"
AMPERAGE	70 – 110	90-160	130-220	200-300
VOLTAGE	21-23	21-23	21-24	22-25

OTHER INFORMATION

- Preheat should be used on hardenable steels to prevent the formation of a hard heat-affected zone.
- Preheat may also be required in welding heavy sections.
- Opened containers should be stored at 225°F to 300°F. They can be reconditioned by baking for one hour at 700°F.

STANDARD PACKAGING

- 3/32" 8 lb. can / 48 lb. box
- 1/8" 10 lb. can / 60 lb. box
- 3/16" 10 lb. can / 60 lb. box
- 5/32" 10 lb. can / 60 lb. box
- All sizes 50 lb. can

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