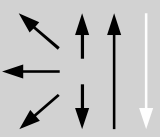


Classifications						
EN ISO 18275-A	EN ISO 18275-B	AWS A5.5	AWS A5.5M			
E 62 6 Mn2NiCrMo B 4 2 H5	E6918-G A H5	E10018-GH4R	E6918-GH4R			
		E10018MH4R (mod.)	E6918MH4R (mod.)			
Characteristics and typical fields of application						
<p>Mn-Mo-Ni -alloyed basic electrode with high ductility and crack resistance for high-strength, quenched and tempered fine-grained constructional steels. Suitable for service temperatures at -60 °C to +400 °C.</p> <p>Weld metal recovery approx. 120 %. Easy weld ability in all positions except vertical-down. Preheat, interpass temperature and post weld heat treatment as required by the base metal. Very low hydrogen content (acc. AWS condition HD < 4 ml/100 g weld metal).</p>						
Base materials						
<p>Quenched and tempered fine-grained steels up to 620 MPa yield strength S500Q-S620Q, S500QL-S620QL, S500QL1-S620QL1, L485MB-L555MB, L485QB-L555QB, alform 500 M, 550 M, 600 M, aldur 550 Q, 550 QL, 550 QL1 ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X70, X80, X70Q, X80Q</p>						
Typical analysis of all-weld metal						
	C	Si	Mn	Cr	Ni	Mo
wt.-%	0.05	0.4	1.6	0.4	2.0	0.4
Mechanical properties of all-weld metal – typical values (min. values)						
Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-60 °C	
u	700 (≥ 620)	750 (690 – 890)	22 (≥ 18)	130	≥ 47	
s	690	750	22	110		
v	450	610	24	120		
u	untreated, as welded					
s	stress relieved 580 °C/2h / furnace down to 300 °C / air					
v	quenched/tempered 910 °C/1h / air and 600 °C/2h / furnace down to 300 °C / air					
Operating data						
	Polarity: DC (+)	Re-drying if necessary: 300 – 350 °C, min. 2 h	Electrode identification: FOX EV 75 10018-G E 62 6 Mn2NiCrMo B	ø mm	L mm	Amps A
				2.5	350	80 – 100
				3.2	350	100 – 140
				4.0	450	140 – 180
				5.0	450	190 – 230
Preheating and interpass temperature and post weld heat treatment as required by the base metal.						
Approvals						
CE						