

## Classifications

EN ISO 18275-A	AWS A5.5	AWS A5.5M
E 89 4 ZMn2Ni1CrMo B 4 2 H5	E12018-GH4R	E8318-GH4R

## Characteristics and typical fields of application

Basic coated electrode with high ductility and cracking resistance for high-strength fine-grained constructional steels.

Low-temperature ductility down to  $-40\text{ }^{\circ}\text{C}$ . Easy welding in all positions except vertical-down. Preheating, interpass temperature and post weld heat treatment as required by the base metal. Deposits have very low hydrogen contents ( $\text{HD} < 4\text{ ml}/100\text{ g}$ ).

## Base materials

Quenched and tempered fine-grained constructional steels with 890 MPa yield strength, QT-steels, low alloyed up to 1000 MPa tensile strength.  
alform plate 900 x-treme, alform plate 960 M x-treme

## Typical analysis of all-weld metal

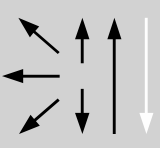
	C	Si	Mn	Cr	Ni	Mo	V
wt.-%	0.06	0.35	1.7	0.7	2.5	0.5	0.07

## Mechanical properties of all-weld metal

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	-40 °C
u	$\geq 890$	980 – 1180	$\geq 15$	$\geq 47$	$\geq 47$

u untreated, as welded

## Operating data

	Polarity: DC (+)	Redrying if necessary: 300 – 350 °C, min. 2 h	Electrode identification: FOX EV 100 12018-G E 89 4 ZMn2Ni1CrMo B	$\varnothing$ mm	L mm	Amps A
				3.2	350	100 – 140
				4.0	450	140 – 180
5.0	450	190 – 230				

## Approvals

TÜV (07629.), VG 95132, CE