

## Classifications

EN ISO 18275-A	EN ISO 18275-B	AWS A5.5	AWS A5.5M
E 55 3 MnMo B T 4 2 H10	E6218-G A H10	E9018-G	E6218-G
		E9018-D1 (mod.)	E6218-D1 (mod.)

## Characteristics and typical fields of application

Basic Mn-Mo alloyed electrode especially suited for high-strength fine-grained constructional steels and high-temperature steels, e.g. 15NiCuMoNb5S. Crack resistant, tough and ageing resistant. Excellent weld ability in all positions except vertical-down.

## Base materials

High-strength fine-grained steels , rail steels up to R 200 (for cladding)  
S460N, S460M, S460Q-S555Q, P460N, P460NH, 415NB, L415MB-L555MB, L415QB-L555QB, alform 500 M, 550 M, aldur 500 Q, aldur 550 Q, 20MnMoNi4-5, 15NiCuMoNb5-6-4, GE300, ASTM A 572 Gr. 65; A 738 Gr. A; A 852; API 5 L X60, X65, X70, X80, X60Q, X65Q, X70Q, X80Q

## Typical analysis of all-weld metal

	C	Si	Mn	Mo
wt.-%	0.06	0.4	1.6	0.5

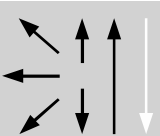
## Mechanical properties of all-weld metal – typical values (min. values)

Condition	Yield strength R <sub>p0,2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-30 °C
u	<b>580</b> (≥ 550)	<b>680</b> (620 – 780)	<b>22</b> (≥ 18)	<b>150</b>	<b>85</b> (≥ 47)
s	<b>580</b>	<b>650</b>	<b>23</b>	<b>160</b>	<b>90</b>

u untreated, as welded

s stress relieved 650 °C/2h / furnace down to 300 °C / air

## Operating data

	Polarity:	Redrying if necessary:	Electrode identification:	ø mm	L mm	Amps A
	DC ( + )	300 – 350 °C, min. 2 h	FOX EV 70 Mo 9018-G E 55 3 MnMo B T	2.5	250	70 – 100
				3.2	350	110 – 140
				4.0	450	140 – 180
				5.0	450	180 – 240

Preheating and interpass temperature, as well as post welds heat treatment as required by the base metal.

## Approvals

TÜV (1178.), DB (10.014.11-82.014.12/03), CE