

Product Data Sheet



BRAND NAME VJ 11018-G

AWS/ASME Class E11018-G

SPECIFICATION SFA A5.5

Features and Applications :

VJ 11018-G is an extra low-hydrogen, low-alloy electrode for welding high-strength steels like HSLA, Q&T, and fine-grained grades. It offers high tensile strength, good ductility, and excellent impact toughness down to -50°C. Suitable for all-position welding with radiographic quality, it is ideal for applications such as penstocks, earth-moving equipment, and heavy steel structure.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.08	Cr	0.80
Mn	1.40	Ni	2.15
Si	0.35	Mo	0.30
S	0.030	P	0.030

MECHANICAL PROPERTIES OF WELD METAL

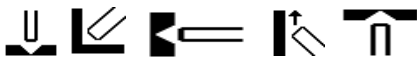
All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	695
UTS (MPa)	785
El (%)	21
Charpy V at -50°C (J)	58

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
2.50 x 350	70	100	150
3.15 x 450	90	140	100
4.00 x 450	140	190	70
5.00 x 450	190	250	45

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 2 hour.