

Product Data Sheet



BRAND NAME VJ 11018-M

AWS/ASME Class E11018-M

SPECIFICATION SFA A5.5

Features and Applications :

VJ 11018-M is a basic coated, hydrogen-controlled electrode that offers smooth arc stability, easy restrike, and low spatter. It produces radiographic-quality welds with excellent crack resistance, high strength, and reliable impact toughness at subzero temperatures.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.06	Cr	0.20
Mn	1.55	Ni	1.90
Si	0.38	Mo	0.40
S	0.030	P	0.030

MECHANICAL PROPERTIES OF WELD METAL

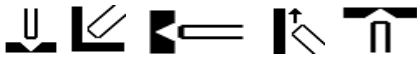
All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	720
UTS (MPa)	795
EI (%)	23
Charpy V at -50°C (J)	58

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
Dia x Length			
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.