

Product Data Sheet



BRAND NAME VJ 12018M

AWS/ASME Class E12018-M

SPECIFICATION SFA A5.5

Features and Applications :

VJ 12018 M is a low-hydrogen electrode that deposits high-strength weld metal with excellent notch toughness. It features alloy additions and moisture control, ensuring radiography-quality welds. The operational characteristics are excellent in all positions. Ideal for welding high-strength steels, low-alloy steels, and micro-alloy steels, it is suitable for both similar and dissimilar material welding, including carbon steels.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.08	Cr	1.00
Mn	1.30	Ni	2.20
Si	0.35	Mo	0.40
S	0.025	V	0.30
P	0.025		

MECHANICAL PROPERTIES OF WELD METAL

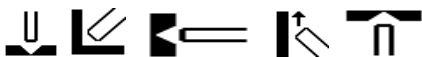
All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	750-830
UTS (MPa)	830 Min
EI (%)	18
Charpy V at -50°C (J)	60 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	60	90	150
3.15 x 450	90	140	100
4.00 x 450	140	190	70
5.00 x 450	190	250	45

CURRENT : DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 300°C for 2 hour.