

# Product Data Sheet



**BRAND NAME** VJ 8018G

**AWS/ASME Class** E8018-G

**SPECIFICATION** SFA/AWS A5.5

## Features and Applications :

VJ 7018-1 is a high-quality electrode, providing high deposition rate. It provides excellent welding pool control, minimal spatter level, good arc strike and easy slag removal. Particularly suitable for welding high strength low-alloy steels. Weld deposit is of Radiographic Quality with very Resistant to hot cracking and excellent Notch Toughness at sub zero temp.

## CHEMICAL COMPOSITION :

| All Weld Metal (%) |            |
|--------------------|------------|
| TYPICAL            | Max        |
| C                  | 0.10       |
| Mn                 | 1.0 - 1.60 |
| Si                 | 0.75       |
| S                  | 0.030      |
| P                  | 0.030      |

## MECHANICAL PROPERTIES OF WELD METAL

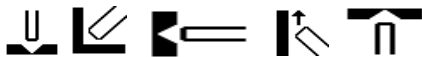
| All Weld Metal - As Welded |         |
|----------------------------|---------|
| Properties                 | Typical |
| YS (MPa)                   | 450-510 |
| UTS (MPa)                  | 510-610 |
| El (%)                     | 25-30   |
| Charpy V at -45°C (J)      | 50-150  |

## DIMENSIONS & CURRENT DATA

| Dimension (mm) | Current (A) |     | Packing (Pcs) |
|----------------|-------------|-----|---------------|
|                | Min         | Max | Qty / Pkt     |
| 2.50 x 350     | 60          | 90  | 150           |
| 3.15 x 450     | 90          | 140 | 100           |
| 4.00 x 350     | 150         | 190 | 70            |
| 5.00 x 350     | 200         | 260 | 45            |

## CURRENT : AC/DC (+)

## WELDING POSITION:



## OTHER DATA:

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