

Product Data Sheet



BRAND NAME VJ 9018G

AWS/ASME Class E9018-G

SPECIFICATION SFA A5.5

Features and Applications :

VJ 9018-G is a low hydrogen iron powder electrode for welding high tensile and fine-grained steels. It ensures excellent toughness and is ideal for bridges, tanks, penstocks, pressure vessels, and structural fabrication.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.08
Mn	1.30
Si	0.35
S	0.030
P	0.030
Mo	0.40
Ni	1.20

MECHANICAL PROPERTIES OF WELD METAL

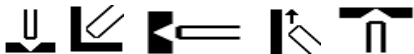
All Weld Metal - As Weld	
Properties	Typical
YS (MPa)	570
UTS (MPa)	680
El (%)	23
Charpy V at -50°C (J)	46

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 450	150	190	70
5.00 x 450	200	260	45

CURRENT : DC (+)

WELDING POSITION:



OTHER DATA:

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