

Product Data Sheet



BRAND NAME VJ 9018M

AWS/ASME Class E9018-M

SPECIFICATION SFA A5.5

Features and Applications :

VJ 9018M is a high-performance electrode for welding high tensile, micro-alloy, and low alloy steels. It produce a smooth arc, medium penetration, low spatter, and easy slag removal. The weld metal shows excellent toughness at sub-zero temperatures from -20°C to -50°C. Its iron powder composition allows higher currents, good arc stability and metal recovery. Ideal for all-position welding in applications like pressure vessels, piping, machinery, and automotive parts.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.10
Mn	0.6-1.25
Si	0.80
S	0.030
P	0.030
Cr	0.15
Mo	0.35
Ni	1.40-1.80
V	0.05

MECHANICAL PROPERTIES OF WELD METAL

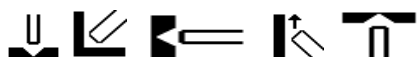
All Weld Metal - As Weld	
Properties	Typical
YS (MPa)	540 Min
UTS (MPa)	620 Min
EI (%)	24
Charpy V at -50°C (J)	50-100

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	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.