

PRODUCT DATA SHEET

Afrox 118



Afrox 118 is a basic hydrogen controlled electrode for all position welding of high tensile low alloy steels. The electrode deposits a weld metal containing approximately 2% nickel and 0,4% molybdenum which, apart from having good tensile properties, is extremely tough and ductile. Aprox 118 produces weld metal of the highest radiographic and metallurgical qualities in all positions. Aprox 118 is recommended for welding a range of fine grained structural steels.

Classifications		
AWS	A5.5	E11018-G
EN	757	E62 5 Mn2NiMo H5

Typical Chemical Analysis			
% Carbon	0,06 - 0,1	% Phosphorous	0,025 max
% Manganese	1,3 - 1,8	% Molybdenum	0,25 - 0,5
% Silicon	0,5 max	% Nickel	1,70 - 2,5
% Sulphur	0,025 max		

Typical Mechanical Properties (All weld metal in the as welded condition)	
0,2% Proof Strength	670 MPa min
Tensile Strength	760 MPa min
% Elongation on 50 mm	20 min
Charpy V-Notch at -51°C	45 J min

Packing Data				
Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
3,15	350	90 - 145	3 x 4,0	W075443
3,15	380	135 - 200	3 x 4,0	W075444
4,0	450	180 - 260	3 x 5,0	W075445

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