

PRODUCT DATA SHEET

Hobart I1018M



Hoballoy I1018M is designed for use in military applications which require weld joints with 100 000 psi minimum tensile strength. This electrode provides excellent puddle control with good wetting action and tie in. The electrode offers good arc characteristics and easy slag removal.

Classifications

AWS	A5.5	EI 1018M H4R
EN	757	E62 5 Mn2NiMo H5

Typical Chemical Analysis

% Carbon	0,07	% Chromium	0,04
% Manganese	1,44	% Molybdenum	0,38
% Silicon	0,40	% Nickel	1,89
% Sulphur	0,007	% Vanadium	0,01
% Phosphorous	0,012		

Typical Mechanical Properties (All weld metal in the as welded condition)

Yield Strength	687 MPa
Tensile Strength	747 MPa
% Elongation on 5d	23
Charpy V-Notch at -51°C	71 J

Packing Data

Diameter (mm)	Electrode Length (mm)	Current (A)	Deposition Rate (kg/hr)	Pack Mass (kg)	Item Number
3,2	350	135	1,10	1 x 22,7 (can)	W075463
4,0	350	175	1,77	1 x 22,7 (can)	W075464
4,8	350	250	2,31	1 x 22,7 (can)	W075465

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