

PRODUCT DATA SHEET

Metrode EI0018-D2



EI0018-D2 is designed to weld higher strength materials with tensile strength requirements of 690 MPa such as AISI 4130, 4140 and 8630. These low nickel consumables satisfy NACE MR0175 requirements intended to ensure resistance to sulphide-induced stress corrosion cracking in sour service, combined with good sub-zero toughness.

Classifications		
AWS	A5.5	EI 1018-D2
EN	757	E62 4 MnMo B

Typical Chemical Analysis			
% Carbon	0,1	% Chromium	0,15
% Manganese	1,8	% Molybdenum	0,35
% Silicon	0,4	% Nickel	0,6
% Sulphur	0,001	% Copper	0,05
% Phosphorous	0,015		

Typical Mechanical Properties (All weld metal in the PWHT condition)		
	PWHT 620°C/1 hr	PWHT 645°C/4 hr
0,2% Proof Stress	690 MPa	620 MPa
Tensile Strength	760 MPa	700 MPa
% Elongation on 5d	21	22
Charpy V-Notch at 0°C	-	>100 J
Charpy V-Notch at -40°C	>27 J	>60 J
Hardness HV	250	230

Packing Data (DC+)				
Diameter (mm)	Current (A)	Electrode Length (mm)	Pack Mass (kg)	Item Number
2,5	70 - 110	350	3 x 4,0	078240
3,2	80 - 140	380	3 x 4,2	078242
4,0	100 - 180	450	3 x 5,6	078244

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