



S. R. Industries

STAR ARC E8018-C3

E8018-C3 welding electrode is designed for 1% nickel applications as well as 80,000 (psi) tensile strength applications. These electrodes provide excellent puddle control with good wetting action and tie in, have good arc characteristics and easy slag removal. WMS 8018-C3 electrodes will provide notch toughness of 20-ft lbs at 40°F. The coating is specially formulated to resist conditions of high heat and humidity. It is also resistant to moisture reabsorption which helps prevent hydrogen cracking and aids in eliminating starting porosity.

Typical Applications : shipbuilding, piping and gas storage tanks, weathering steels, cross country pipe repair for 3/32" electrodes, the upper value for yield may be 5 kpsi higher than indicated.

AWS Class : E8018-C3 H4	Classification : AWS A5.5/A5.5M:2006
Alloy : E8018-C3	ASME SFA A5.5
Welding Position: F, V, OH, H	Current : AC-DCEP
Tensile Strength, kpsi:	80
Yield Strength, kpsi:	68-80
Elongation in 2" (%):	24

Typical Wire Chemistry as per AWS A5.5 (single values are maximum)

C	Mn	Si	P	S	Ni	Cr	Mo	V
0.12	0.40-1.25	0.80	0.03	0.03	0.80-1.10	0.15	0.35	0.05

Typical Welding Parameters

Diameter		Process	Amps (flat)	Amps (V/OH)
in	(mm)			
3/32	(2.4)	SMAW	70-11	60-95
1/8	(3.2)	SMAW	90-160	80-120
5/32	(4.0)	SMAW	130-22	110-170
3/16	(4.8)	SMAW	190-290	---

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