



Atom Arc 10018-MM



Atom Arc 10018-MM electrodes are used to weld low-alloy, high-tensile steels where welds of 100 ksi (690 MPa) minimum tensile strength is required. This electrode is recommended for use in the weld repair and fabrication of Mn-Mo steel castings and armor plate.

Classifications	AWS A5.5 : E10018-D2 H4R ASME SFA 5.5
Welding Current	AC or DC+
Coating Type	Low-hydrogen iron powder

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Stress Relieved 1hr 621°C (1150°F)	-51 °C (-60 °F)	33 J (24 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.081	1.93	0.33	0.01	0.01	0.32	0.17	0.34	0.011	0.083

Typical Weld Metal Analysis %

Nb
0.004