

PRICES FOR ARC WELDING – Mild Steel and Low Hydrogen/Low Alloy Electrodes

USA 12018M
AWS A5.5 Class E12018M

DESCRIPTION
 USA 12018M is an all-position, low-hydrogen iron powder electrode containing manganese, chromium, nickel and molybdenum. USA 12018M was developed for welding high strength steels requiring a weld deposit tensile strength of 120,000 psi minimum. The weld deposits of USA 12018M have excellent impact properties and are X-ray quality.

PREHEATING AND POSTHEATING
 Depending upon the thickness and hardening characteristics of the work piece, preheating at a temperature between 140-220°F is recommended. Do not exceed the recommended preheat temperatures as excessive heat input can cause a deterioration of impact values and the yield strength of the weld deposit.

TYPICAL APPLICATIONS
 USA 12018M is designed for welding high tensile strength steels such as ASTM A148 Gr. 120-95, A238 Gr. F, A291 class 4, A514 and many other specifications all requiring a weld deposit tensile strength of 120,000 psi minimum.

TYPICAL WELD METAL CHEMISTRY (%)

C	0.08
Si	0.30
Mn	1.46
Cr	0.98
Ni	1.86
Mo	0.41

TYPICAL MECHANICAL PROPERTIES OF WELD DEPOSIT (as welded)

Yield point (psi)	117,000
Tensile strength (psi)	138,000
Elongation in 2" (%)	20
Charpy V-notch at -60°F (ft. lbs.)	36

AVAILABLE SIZES AND RECOMMENDED CURRENTS (AC or DC+)

Dia. (in.)	3/32	1/8	5/32	3/16	7/32	1/4
Lgth. (in.)	14	14	14	14	14	18
Amps F	50-95	90-130	130-190	190-250	230-280	250-320
V&O40-95	80-120	100-160	120-160	150-210	-	-

CALL FOR INFORMATION ON LARGE DIAMETER ELECTRODES



TYPICAL CERTIFICATIONS CHEMICAL & MECHANICAL PROPERTIES ARE INCLUDED ON THE PRECEDING PAGES. CALL FOR PRICE AND AVAILABILITY IF ACTUAL CERTIFICATIONS ARE REQUIRED EITHER PROPERTY. (PRIOR TO PURCHASE OF ELECTRODE)

7010-A1			
All Sizes		3 PAGES	
\$25.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	7010-A1-332-10	7010-A1-332-60	\$99.00
1/8	7010-A1-18-10	7010-A1-18-60	\$85.00
5/32	7010-A1-532-10	7010-A1-532-60	\$85.00
3/16	7010-A1-316-10	7010-A1-316-60	\$85.00

A VARIATION OF 7018 (earlier pg.)			
All Sizes		3 PAGES	
\$25.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	7018-A1-332-10	7018-A1-332-60	\$99.00
1/8	7018-A1-18-10	7018-A1-18-60	\$85.00
5/32	7018-A1-532-10	7018-A1-532-60	\$85.00
3/16	7018-A1-316-10	7018-A1-316-60	\$85.00

7018-B2L			
All Sizes		3 PAGES	
\$35.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	7018-B2L332-10	7018-B2L332-60	\$135.00
1/8	7018-B2L18-10	7018-B2L18-60	\$125.00
5/32	7018-B2L532-10	7018-B2L532-60	\$125.00
3/16	7018-B2L316-10	7018-B2L316-60	\$125.00

7028			
All Sizes		3 PAGES	
\$25.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
1/8	7028-18-10	7028-18-60	\$85.00
5/32	7028-532-10	7028-532-60	\$85.00
3/16	7028-316-10	7028-316-60	\$85.00
7/32	7028-732-10	7028-732-60	\$85.00

8018-B2			
All Sizes		2 PAGES	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	8018-B2-332-10	8018-B2-332-60	\$125.00
1/8	8018-B2-18-10	8018-B2-18-60	\$115.00
5/32	8018-B2-532-10	8018-B2-532-60	\$115.00
3/16	8018-B2-316-10	8018-B2-316-60	\$115.00

8018-C1			
All Sizes		2 PAGES	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	8018-C1-332-10	8018-C1-332-60	\$135.00
1/8	8018-C1-18-10	8018-C1-18-60	\$125.00
5/32	8018-C1-532-10	8018-C1-532-60	\$125.00
3/16	8018-C1-316-10	8018-C1-316-60	\$125.00

8018-C2			
All Sizes		2 PAGES	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	8018-C2-332-10	8018-C2-332-60	\$135.00
1/8	8018-C2-18-10	8018-C2-18-60	\$125.00
5/32	8018-C2-532-10	8018-C2-532-60	\$125.00
3/16	8018-C2-316-10	8018-C2-316-60	\$125.00

ADDITIONAL - MILD & LOW ALLOY STEEL ELECTRODES 4 PAGES

MILD & LOW ALLOY STEEL ELECTRODE INFORMATION 6 PAGES

8018-C3			
All Sizes		2 PAGES	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	8018-C3-332-10	8018-C3-332-60	\$125.00
1/8	8018-C3-18-10	8018-C3-18-60	\$115.00
5/32	8018-C3-532-10	8018-C3-532-60	\$115.00
3/16	8018-C3-316-10	8018-C3-316-60	\$115.00

8018-B3L			
All Sizes		NEXT PAGE	
\$35.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	8018-B3L332-10	8018-B3L332-60	\$145.00
1/8	8018-B3L18-10	8018-B3L18-60	\$135.00
5/32	8018-B3L532-10	8018-B3L532-60	\$135.00
3/16	8018-B3L316-10	8018-B3L316-60	\$135.00

9018-B3			
All Sizes		NEXT PAGE	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	9018-B3-332-10	9018-B3-332-60	\$140.00
1/8	9018-B3-18-10	9018-B3-18-60	\$130.00
5/32	9018-B3-532-10	9018-B3-532-60	\$130.00
3/16	9018-B3-316-10	9018-B3-316-60	\$130.00

9018M			
All Sizes		NEXT PAGE	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	9018M-332-10	9018M-18-60	\$109.00
1/8	9018M-18-10	9018M-532-60	\$95.00
5/32	9018M-532-10	9018M-316-60	\$95.00
3/16	9018M-316-10	9018M-732-60	\$95.00

11018M			
All Sizes		NEXT PAGE	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	11018M-332-10	11018M-332-60	\$109.00
1/8	11018M-18-10	11018M-18-60	\$95.00
5/32	11018M-532-10	11018M-532-60	\$95.00
3/16	11018M-316-10	11018M-316-60	\$95.00

12018M			
All Sizes		THIS PAGE	
\$30.00 PER 10 LB PACK		60 LB in *Standard Container	
SIZE	PART No.	PART No.	PRICE
3/32	12018M-332-10	12018M-332-60	\$135.00
1/8	12018M-332-10	12018M-332-60	\$130.00
5/32	12018M-332-10	12018M-332-60	\$130.00
3/16	12018M-332-10	12018M-332-60	\$130.00

***A (60 lb.) Moisture Resistant Container, houses 6 resealable 10 lb plastic packages. If a metal container is required, contact us for ordering information.**