



PRODUCT DATA SHEET

HIGH TENSILE LOW HYDROGEN ELECTRODES

HOBALLOY 11018M



SUMMARY

- > Good arc characteristics
- > Good ductility
- > Low spatter level
- > Quick and easy slag removal
- > Low moisture reabsorption
- > Low smoke level
- > Low hydrogen - less than 4ml/100g

CLASSIFICATION

- > AS/NZS 4857: B-E7618-N4M2 A U H5
- > AWS A5.5 E11018M H4R

DESCRIPTION AND APPLICATION

Outstanding electrode designed for use in Military applications and other projects that require weld joints with 690 MPa minimum tensile strength. Hoballoy 11018M offers a wide range of welding advantages that will improve your welding productivity – good arc characteristics, excellent puddle control with good wetting action and tie-in, and easy slag removal. Ideal for conditions of high heat and humidity, it features a special coating that’s designed to reduce moisture pick-up, helping to minimise hydrogen cracking and starting porosity. Hoballoy 11018M also offers good ductility, good crack resistance and high notch toughness even at temperatures as low as -50 °F. Single and multiple pass, DCEP, AC. Typical applications include low-alloy steels including HY-80, HY-90, T-1 and matching strength weld of Bisalloy 80.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
3.2	355	90 - 160
4.0	355	130 - 220

*Recommended for DC + or AC (minimum 70 OCV).
Voltage is determined by arc current and electrode arc length.
Arc voltage shown is typical and is only to be used as a guide.

APPROVALS

- > DNV 5 Y69 H5 (3.2MM)

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	P	S	Si	Cr	V	Ni	Mo
0.04	1.57	0.015	0.010	0.34	0.19	0.010	1.99	0.29

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength	736 MPa
Tensile Strength	799 MPa
Elongation	22%
CVN Impact Values	76J @ -50 °C

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING	PART NO.
	KG PER PACKET	
3.2	4.5	HOBALLOY11832
4.0	4.5	HOBALLOY11840

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