



Product Data Sheet

Superior Corrosion Resistant Electrode.

SUPER OPTIMAL 8018W2

Classification: AWS A 5.5: E 8018 – W2

Description / Properties: Specially designed low hydrogen, moisture resistance basic type copper bearing corrosion resistance electrode for low alloy, weathering-type structural steels. Excellent weldability in all positions. Easy slag removal, finely rippled smooth weldbead.

Applications: Electrode for welding of weathering steels, CORTEN-A and CORTEN-B and their equivalents.

Materials: ASTM A 242 and A 588

Weld metal chemical composition:
(typical)%

C	Si	Cu	Mn	Cr	Ni	P	S
0.08	0.50	0.50	1.00	0.60	0.60	0.025	0.015

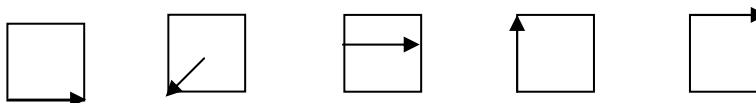
All weld metal: mechanical properties (typical)

Yield strength N/mm ²	Tensile strength N/mm ²	Elongation A ₅ %	Charpy impact value ISO-V J - 20°C
>480	560-650	>21	>47

Diffusible Hydrogen: 4ml max.
(per 100g weld metal)

Welding recommendations: DC(+) / AC₇₀ Re-drying: 300-350°C/1h

Welding positions:



Welding current:

2.50	3.15	4.0	5.0
60- 90	100- 140	140- 180	190- 250