

Classifications

Characteristics and typical fields of application

Basic coated MnNiMo alloyed electrode.

Very low H₂-content < 5 ml/100 g; extremely high resistance to cracking and high toughness at temperatures as low as -40°F.

For creep resistant steels and cast steel grades, valves and oil tools according to sour gas specification; postweld heat treatment: stress relieving according to parent metal.

Base materials

G30CrMoV6-4, GS-30CrMoV6-4

Steels acc. ASTM A 487-4Q; AISI 4130

Typical analysis

	C	Si	Mn	Ni	Mo
wt.-%	0.09	0.3	1.9	0.9	0.4

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J		
	ksi	ksi	%	68°F	-40°F	-58°F
u	94 (≥ 90)	112 (100 - 129)	20 (≥ 18)	89 ftlb	52 (≥ 35) ftlb	44 ftlb
s	91	106	21	96 ftlb	52 ftlb	44 ftlb

u untreated, as welded

s stress released at 1175°F/4h

Operating data

	Polarity	DC+	Dimension inch	Current A
	Electrode identification	FOX NiMo / E 62 4 Mn1NiMo B / E10018-D2	3/32" × 14"	70 – 100
			1/8" × 14"	100 – 150
			5/32" × 14"	140 – 200
			5/32" × 18"	140 – 200
			~3/16" × 18"	180 – 250

Choose preheating, interpass temperature and post weld heat treatment (PWHT) as required by the base material.

Approvals

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