

## Atom Arc 8018-N



Atom Arc 8018-N electrodes produce excellent weld properties and are used to fabricate components where low temperature notch toughness values are required. Atom Arc 8018-N is also recommended for welding the 2% to 4% Ni steels.

<b>Classifications</b>	AWS A5.5 : E8018-C2 H4R ASME SFA 5.5
<b>Welding Current</b>	AC or DC+
<b>Coating Type</b>	Low-hydrogen iron powder

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-10 °C (-50 °F)	77 J (57 ft-lb)
As Welded	-73 °C (-100 °F)	47 J (35 ft-lb)
Stress Relieved 1hr 621°C (1150°F)	-73 °C (-100 °F)	33 J (24 ft-lb)

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.042	1.01	0.28	0.01	0.01	3.29	0.05	0.02	0.009	0.096

### Typical Weld Metal Analysis %

Nb
0.003