

Typical Applications:

- Designed to meet **NACE MR0175**: <1%Ni, Max 250 Vickers (22HRC)
- Boiler and Pressure Vessel Fabrication
- Manganese Casting Repair
- Alloy Casting Repair and Fabrication
- Resistance to PWHT Strength Reduction

Product Advantages:

- Flat, Horizontal, Vertical
- Minimal moisture pickup
- Flat bead with easy slag release
- Low Spatter
- Consistent Arc Re-strike
- Low Hydrogen

Typical Mechanical Properties – Stress Relieved

	UTS (ksi)	Yield (ksi)	%El	CVN (ft/lbs) @ -60F	Vickers
AWS Spec.:1hr. @1150°F	100	87	16	20	-
10018-SR+: 1hr. @ 1150°F	116	108	21	26	-
10018-SR+: 4hr. @ 1180°F	106	95	24	32	210
10018-SR+: 12hr. @ 1180°F	101	90	25	22	240

Typical Deposit Composition

	%C	%Mn	%Si	%Ni	%Mo
AWS Spec.(Max.)	0.15	1.69 – 2.00	0.80	0.90	0.25 - 0.45

Available Diameters: 3/32", 1/8", 5/32", 3/16" (Additional sizes may be available upon request)

Typical Welding Parameters (DCEP)

Diameter	Amperage Range	Current
3/32"	85 – 100	DCEP
1/8"	120 – 140	DCEP
5/32"	150 – 170	DCEP
3/16"	185 – 200	DCEP

Packaging: Electrodes are vacuum-sealed in 10 lb. boxes in a climate-controlled room to eliminate all moisture and then placed in 40 lb. master cartons.

Moisture Control: Devasco electrodes are manufactured and packaged to resist moisture pick up. New or open electrodes should be stored in their original packaging (if heat resistant) in a storage oven at 300° F - 325° F with a maximum humidity of 70%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 500-800°F in a warming oven for a minimum of 1 hour for reconditioning prior to use.

NOTICE: Data provided is based on typical results. **Actual results are tested per customer spec.** Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. www.devasco.com for additional information.

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