

# Excabur® 11018M MR

## Key Features

- Capable of producing weld deposits with
- 760 MPa (110 ksi) tensile strength
- Premium arc performance
- Square coating burn-off
- Easy strike and re-strike
- Effortless slag removal

## Typical Applications

- Quenched and tempered steels, such as A514, A517 and A709
- General fabrication of high strength steels
- Crane booms
- Trailer frames

## Conformances

**AWS A5.5/A5.5M: 2006** E11018M H4R

**ABS:** 4YQ690 H5

**DNV Grade:** 4 YM69 H5

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	ED032607	Easy Open Can 4.5kg (3 x EOC per carton)
4.0	350	ED032608	Easy Open Can 4.5kg (3 x EOC per carton)

## Mechanical Properties - As required per AWS A5.5 / A5.5M: 2006

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -50°C
<b>Requirements - AWS</b>	680-760	760 min	20 min	27 min
<b>Typical Results - As Welded</b>	690-758	765-807	20-26	76-103

## Deposit Composition

	%C	%Mn	%Si	%P	%S
<b>Typical Results - As Welded</b>	0.04-0.05	1.55-1.80	0.40-0.55	≤ 0.02	0.01-0.03
	%Ni	%Cr	%Mo	Diffusible Hydrogen	
<b>Typical Results - As Welded</b>	2.0-2.5	0.02-0.20	0.40-0.50	1-4 ml / 100 g	

## Typical Operation Procedures

Polarity	Current (amps)	
	3.2mm	4.0mm
DC+	90-160	130-210