

ESAB 98



ESAB 98 is a Cr-Ni-Mo alloyed hydrogen controlled iron powder type electrode, for welding high tensile strength steels. The electrode deposits, tough and crack resistant welds. The optimum addition of iron powder permits the use of higher currents and results in improved arc characteristics coupled with higher metal recovery. The operational characteristics are excellent in all positions. ESAB 98 finds extensive use in pressure vessels, piping, penstock, earth moving equipment, machinery parts, automobile parts, chemical plants etc.

Classifications:	SFA/AWS A5.5:E9018M
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Welding Current:	AC, DC+
Diffusible Hydrogen:	< 5 ml/100g
Alloy Type:	Cr-Ni-Mo alloyed
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	570 MPa	640 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-50 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	1.00	0.40	1.60	0.10	0.25

Current Range

Diameter	Current
2.5 x 350 mm	50-90 A
3.15 x 450 mm	90-140 A
4.0 x 450 mm	140-190 A
5.0 x 450 mm	190-240 A