



EM 180



High strength cellulosic electrode for pipe welding. **AWS/ASME SFA 5.5 E 11018-H4**

Key Benefits

- Heavy coated basic type electrode for welding fine grained and high strength structural steel which have yield strength up to 690 N/mm² (e.g. WELDOX 700) and tensile strength up to 850 N/mm²
- Due to high toughness, crack resistance even under difficult conditions such as dynamic loads high and low environmental temperatures.

Welding Positions



Typical Applications

- Suitable for welding high strength steels used in fabrication of crane, earth moving equipment, heavy machinery parts
- Suitable for joining and repair welding of light steel fabrications, iron works, wrought iron work

Typical Chemical Composition

Typical Chemical Analysis	%C 0.05	%Mn 1.6	%Si 0.3	%S	%P
Typical Chemical Analysis	%Cr 0.4	%Ni 1.9	%Mo 0.45	%Cu	%Ti

Mechanical Properties

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation (%)	Impact Energy (J)
Typical Results (all weld metal) As Welded	700 MPa	850 MPa	18	-60°C → 50J

Ordering Information

Product Code	AWS Specification	Dimension mm/inches	Single Pack Weight kg/lb	Box Weight kg/lb
1153316M15	EM 180 (11018-G H4)	3.25 x 350 mm (1/8" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1153324M15	EM 180 (11018-G H4)	4.00 x 450 mm (5/32" x 18")	6.5 kg (14.3 lb)	19.5 kg (43.0 lb)
1153332M15	EM 180 (11018-G H4)	5.00 x 450 mm (3/16" x 18")	6.5 kg (14.3 lb)	19.5 kg (43.0 lb)
115338M15	EM 180 (11018-G H4)	6.00 x 450 mm (1/4" x 18")	6.5 kg (14.3 lb)	19.5 kg (43.0 lb)



Single Pack (5.0 kg)



Box (15.0 kg)