

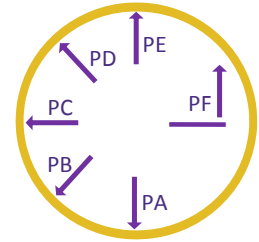
## Applications

- TSC 8018-C1 is an iron powder and low hydrogen type stick electrode for all position welding.
- In contribution of 2.5%Ni in the weld metal.

## Features

- Good impact value at -60°C.
- Iron powder and low hydrogen type electrode(High efficiency)

## Welding Position



## Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.060	0.31	0.92	0.007	0.006	0.035	2.25

## Typical Mechanical Properties of All-Weld Metal

Ys MPa	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C	CVN-Impact Value J°C	Heat Treatment
475	580	26	-60	95	605°C x1hr S.R

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	450 (18)	450 (18)	450 (18)

F	70-100	100-140	140-180	180-230
V-up, OH	60-90	90-130	120-160	

## Current

AC or DC +

## Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

## Notes on Usage

- Because of excessive heat input, the impact value tends to be lower. Therefore, choose proper heat input.
- Preheat treatment before welding at 90-110°C and try to keep low hydrogen situation during whole welding process.
- Keep short arc length when welding.

## Packing Details

4Kg Pack / 16 Kg Ctn ( Vacuum Packing)