

E7018

AWS A5.1 E7018
ISO2560-A E42 3 B 1 2
GB/T5117 E5018

Description:

An iron powder , low hydrogen basic carbon steel electrode designed for all positional welding, Excellent mechanical performance , impact value can be as high as 150J @ -30 °C. AC & DC.
Used to weld the Marine steels (A、B、D、E、AH36、DH36、EH36) and the same grade strength low carbon steel structures, like Boilers、 Pressure Vessels and Offshore drilling platforms etc.

Welding Position:



Diameters:

1.6mm, 2.0mm, 2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	550
Yield strength(MPa):	440
Elongation (%):	28
Impact values(≥ 47)/-30°C):	150

Typical Chemical Composition:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.072	1.26	0.017	0.012	0.52	0.008	0.027	0.030	0.017

Welding Current:(AC/DC+)

Diameter(mm)	2.5	3.2	4.0	5.0
Current/A	F/H 70-110	100-140	140-170	190-240
Current/A	V/OH 60-70	80-110	130-150	--

Note:

- 1.The electrodes must be baked 1-2 hours in 350°C-450°C before using.
- 2.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.