

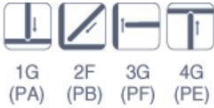
E7018-1

AWS A5.1 E7018-1
ISO2560-A E42 4 B 3 2
GB/T5117 E5018-1

Description:

An improved formulation of E7018, which ensures good impact value at -45°C.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	572
Yield strength(MPa):	480
Elongation (%):	28
Impact values(≥47)/-45°C):	110

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0,060	1,26	0,017	0,012	0,25	0,008	0,028	0,035	0,014

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.
- 3.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.