

E7018

LOW HYDRGOEN STEEL WELDING ELECTRODE

120% DEPOSITION RATE

SIZE	AMPS
2.5mm	50-90A
3.2mm	90-130A
4.0mm	130-180A
5.0mm	180-240A

TYPICAL APPLICATIONS

1. Heavy steel fabrication
2. Shipbuilding
3. Pressure vessels

CHARACTERISTICS

1. 120% deposition rate due to high iron powder content in the flux
2. All positional welding capability
3. Good crack resistance and X-ray quality weld bead
4. CVN impact value at -30°C can be as high as 180J

CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Mn	Si	S	P
0.06	1.20	0.50	0.012	0.010

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Charpy V notch (J)
AW	550	455	28	-30°C 180

Note:

- ① Re-drying it at 350°C for 1-2 hours before using is necessary.
- ② Rust, oil, water, etc should be removed from the weld parts before welding.

CLASSIFICATION

AWS A5.1 E7018
EN ISO2560-A E42 3 B 1 2

PACKING SPECIFICATION

*1kg PE bag
*5kg Cardboard Box

CURRENT TYPE

AC/DC+

AVAILABLE SIZES (DIA./LENGTH)

2.5mm*350mm
3.2mm*350mm
4.0mm*400mm
5.0mm*400mm

EQUIVALENT TO

Lincoln Baso 48SP
Esab OK48.00
Hyundai S-7018.G
Kiswel K-7018
Indura 7018