

AWS E7018

DESCRIPTION:

AWS E7018 is a iron powder low hydrogen type carbon steel welding electrode.It can be used for all position welding with excellent performances:small spatters,easy restrike arc,high welding efficiency,fine appearance and slag easy to remove,etc.The seam weld metal shows a satisfactory plasticity,excellent low temperature toughness and high crack resistance.Both AC and DC can be applied.

APPLICATION:

Suitable for welding important medium carbon steel and low alloy steel,such as 16Mn steel,parts of ships fabricated by A,B,D,E grade steel as well as parts of boilers,presure vessels and pipes.

ATTENTION:

- Welding electrodes should be baked at the temperature of 350C for one hour before welding,and then use them when baking.
- Before welding,the weld metal must be cleared away impurities,such as rust,oil,moisture,etc.
- Short arc and narrow weld bead are recommended in welding.

Chemical Composition of Deposited Metal: (%)

	C	Mn*	Si	S	P	Cr*	Ni*	Mo*	V
Standard	-	≤1.60	≤0.75	≤0.035	≤0.040	≤ 0.20	≤ 0.30	≤ 0.30	≤ 0.08
Typical	0.065	1.38	0.44	0.012	0.020	0.011	0.015	0.001	0.002

The Element With*≤1.50%

Mechanical Properties of Deposited Metal

	Tensile Strength σ_b (Mpa)	Yield Point $\sigma_{0.2}$ (Mpa)	Elongation δ_5 (%)	Akv Impact (-30℃) (J)
Standard	≥490	≥400	≥22	≥27
Typical	550	460	31	130

Diameter and Recommended Current(AC>70V or DC*>70V)

Diameter(mm)	Φ 2.5	Φ3.2	Φ 4.0	Φ 5.0
Length(mm)	300	350	400	400
Current(A)	70-110	100-140	140-180	190-240