S-7018.GH

Type : Basic

Conformances

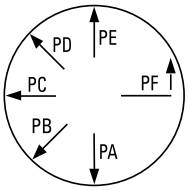
AWS A5.1/ ASME SFA5.1 E7018
JIS Z3211 E4918 H5
EN ISO 2560-A-E42 3 B 3 2 H5
CWB CSA W48 E4918-H8

CWB CSA W48 E4918

Applications

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

Welding Position



Features

- Low hydrogen electrode
- Iron powder and low hydrogen type electrode (high efficiency)
- Good mechanical properties
- Vacuum sealed package available (HDM ≤ 5ml/100g)

Current

AC or DC +

Redrying Conditions

350~400°C (662~752°F) X
0.5~1hr

Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
mm (in)	mm (in)	packet	carton	packet	carton	packet	carton	packet	carton
		5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)	√		√		√		√	
3.2 (1/8)	350 (14)	√		√		√		√	
4.0 (5/32)	400 (16)	√		√		√		√	
5.0 (3/16)	400 (16)	√		√		√		√	
6.0 (15/64)	450 (18)	√		√		√		√	

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.42	1.21	0.018	0.006

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
488 (70,800)	566 (82,100)	27.4	-30 (-22)	126 (93)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14) -	350 (14) 400 (16)	400 (16) 450 (18)	400 (16) 450 (18)	450 (18)
F	60~90	90~140	130~190	180~240	250~300
V-up, OH	50~80	80~120	120~170	150~200	-