E 7018

C-Mn STEEL (Low Hydrogen)
Welding electrode for Structural welding

MAARS
Weld Company Limited

CLASSIFICATION:	EN ISO 14341-A	AWS A/SFA 5]	APPROVALS
	E42 3B 32	E 7018	CE/BIS/BHEL/IRS/IBR/Gr.2, DNV Gr.2, Ordnance, Factory Medak, Cethar Vessels, APPGCL

KEY FEATURES:

- A basic coated, low hydrogen, iron powder type all position electrode
- The welds are of radiography quality.
- Operates on both AC & DC
- The slags are easily removable.
- The weld metal possesses good mechanical properties.

WELDING POSITION:

AC(50 OCV min.)/ DCEN

TYPICAL APPLICATIONS:

- Typical for pressure vessels, pipelines, ship buildings.
- Wagons, coaches, earth moving equipment's.
- Atomic reactor shells.
- Blast furnace steel work, penstocks.

REDRYING CONDITION: 250 – 300 ° C for minimum 1 hr

CHEMICAL COMPOSITION OF UNDILUTE WELD METAL:

	C	Mn	Si	P	S
Typical Value	0.05 – 0.10	0.80 – 1.60	0.30 – 0.75	0.03	0.03
Specification	0.15 max	1.60 max	0.75 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition		UTS, Mpa	YS at 0.2 % offset, Mpa	EL%	CVN Impact at -0°C, JULES
Typical	As Welded	510 – 650	490 – 530	24- 28 min	27 J
Specification		490 min	400 mir	20min	50 - 70 J

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	Wt./Carton Kg	Carton/Box	Approx. wt. of 1000 pcs, Kg.
2.5 x 350	60- 100	150	4	15.5
3.15 x 350	100- 140	120	4	22.5
4.0 x 450	140- 190	80	4	22
5.0 x 450	190- 250	55	4	22