WELDWIRE	DATA SHEET MILD STEEL ELECTRODES	Page: 1 of 1 Date: 11/6/2013 Product: E7018 Class: AWS A5.1-04

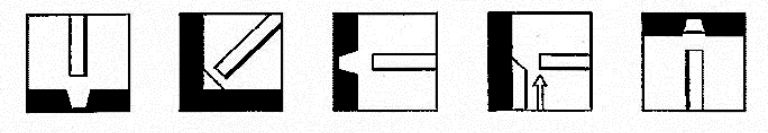
Classifications

AWS A5.1-04	: E7018		
EN ISO 2560-A:2006	: E 42 3 B 32 H10	KS D 7006	: E5016
EN ISO 2560-B:2006	: E 49 18 A U H10	JIS Z 3211	: E4918

Description

*Covering is low hydrogen, iron powder type for welding of 490MPa class high tensile steel in ships, bridges, storage tanks, building and industrial machinery.
*Excellent mechanical properties and radiographic soundness.
*Satisfactory bead appearance and slag removal.
*Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.07	0.61	0.87	0.015	0.011	0.02	0.03	0.01	0.01	0.94

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J) -20°C	IV (J) -30°C	Remarks
AWS A5.1	min. 400	min. 490	min. 22		≥ 27	
EN ISO 2560-A	min. 420	500~640	min. 20		≥ 47	
Example	480	570	30	100	70	AW

*AW: As-Welded

Sizes available and recommended currents (AC or DC+)

Dia.	inches	3/32	1/8	5/32	3/16	1/4
Amp.	F	60~100	90~130	130~180	200~250	250~310
(A)	V * OH	50~80	80~120	110~170	160~210	-----

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3YH10,E7018	3YHH	3YH10	3YH10	3YH15	3YmH15	KMW53H

*Others : KS, JIS, CWB, CE