



Product Data Sheet

E 'Manual metal-arc welding'

Weld 7018

Prepared by P-O Oskarsson	Qualified by P-O Oskarsson	Approved by Mathankumar M.	Reg no EN007614	Cancelling EN007394	Reg date 2017-09-08	Page 1 (2)
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REASON FOR ISSUE

New approval scope.

GENERAL

Weld 7018 is a general - purpose basic DC + electrode for welding of mild and low alloy steels. Easy to use providing good mechanical properties. Weld 7018 is an excellent all round performer with good welder appeal, covering many applications of mild and low alloy steels.

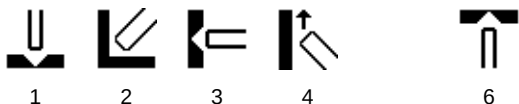
Polarity: DC+(-)

Alloy Type: Carbon Manganese

Coating Type: Basic covering

Diff Hydrogen: < 5.0ml/100g

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1 E7018
EN ISO 2560-A E 42 3 B 42 H5

APPROVALS

ABS 3Y H5
CE EN 13479

APPROVALS (SPECIFIC)

BKI 3Y H5

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.02	0.10
Si	0.30	0.70
Mn	0.90	1.40
P		0.030
S		0.020

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS	
	As welded Min	Max	As welded Min	
Rp0.2 (MPa)			400	
ReL (MPa)	420			
Rm (MPa)	500	640	490	
A4 (%)	20		22	
A5 (%)				
Charpy V at -30°C (J)	47		27	



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	55	105	2,3	117	0,61	71,4	0,87	57,7	23	1,2,3,4,6
3.2 x 350	80	140	3,5	115	0,62	46	1,16	67,1	24	1,2,3,4,6
4.0 x 400	110	200	6,0	113	0,64	26	1,67	82	24,5	1,2,3,4,6
4.0 x 450	110	200	6,7	116	0,675	22	1,8	91	25	1,2,3,4,6
5.0 x 400	160	260	9,2	112	0,65	17	2,4	90	24,5	1,2,3,4

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)