

7018 A1

CATEGORY	SMAW Stick Electrodes
TYPE	Basic low hydrogen electrode with 0.5% Mo
APPLICATIONS	Mo alloyed basic electrode for welding heat and creep-resistant steels with yield strength up to 460 N/mm ² .
PROPERTIES	Excellent welding characteristics and easy slag removal with remarkable out of position weldability. Suited for working temperatures of -40°C to 525°C. Mostly used for the construction of boilers and pipes (15Mo3). Hydrogen content (HD < 5 ml/100 g).
CLASSIFICATION	AWS A 5.5: E 7018-A1 EN ISO 3580-A: E Mo B 42 H5 DIN 1913: E Mo B2
SUITABLE FOR	17Mn4, 19Mn5, 15Mo3, 16Mo3, P235GH, P265GH, A 204 Gr. A-C, St 35.8, St 45.8, StE 480.7 TM, L485, StE460, S460, X65, X70
APPROVALS	TUV and CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
0.10	0.8	0.5	-	-	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>460	530-630	>22		>47		

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) AC/DC+	kg / can	kg / 6pack	kg / 1000
2,5	300	65-95	2,4	14.4	19.8
3.2	350	110-140	2,4	14.4	36.4
4,0	450	140-180	3.2	19.2	66.7
5.0	450	180-230	3.2	19.2	101.9

REDRYING TEMPERATURE 400°C / 1hr