

# S-7018.1

Type : Basic

## Conformances

AWS A5.1/ ASME SFA5.1 E7018-1  
 JIS Z3211 E4918  
 EN ISO 2560-A-E42 4 B 3 2  
 ABS 3H10, 3Y  
 BV 3Y HH  
 LR 3Y H15  
 DNV-GL 3Y H10  
 RINA 3Y H10

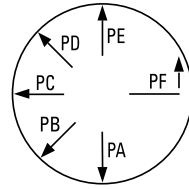
## Applications

- Heavy steel fabrication
- Low temperature strength steel
- Offshore structure

## Features

- Suitable for butt and fillet welding of thin and medium-thick plates (up to 20mm)
- Iron powder and low hydrogen type electrode (high efficiency)
- Good impact value at -45°C

## Welding Position



## Current

AC or DC +

## Redrying Conditions

300~350°C (572~662°F) X  
 0.5~1hr

## Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard / P.V.C	
		packet 5kg(11lbs)	carton 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
0.06	0.25	1.25	0.017	0.012

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
480 (69,700)	550 (79,800)	30.2	-45 (-49)	94 (70)

## 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)
F	60~90	90~140	130~190	180~240	250~300
V-up, OH	50~80	80~120	120~170	150~200	-