

S-7018.W

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E7018-W1

JIS Z3214 DA5026G

EN ISO 2560-A-E42 2 B 3 2

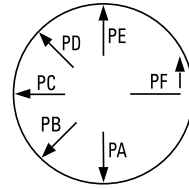
Applications

- High tensile weathering steel

Features

- Suitable for off- and on-shore construction
- High resistance to corrosion caused by seawater or combinations of oil, gas and seawater
- Contains Cu, Ni and Cr (All-weld metal)

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	
		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	Cr	Ni	Cu
0.05	0.56	0.62	0.015	0.013	0.24	0.23	0.37

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
505 (73,300)	573 (83,200)	31.3	-20 (-4)	100 (74)

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	-