

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, P295GH, P310GH, A 204 Gr. A-C, St 35.8, St 45.8, StE 480.7 TM, L485, StE460, S460, X65, X70, 1.5415, 1.0481, 1.0482	
APPROVALS	TUV (12533.00), 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

PARAMÈTRES DE SOUDAGE / EMBALLAGE

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