SME 7018

LOW HYDROGEN ELECTRODE (MMAW)

Classification

AWS A/SFA 5.1 : E7018 EN ISO 2560-A : E42 4 B 42 IS 814 : EB 5626

Characteristics :

SME 7018 is a low hydrogen, iron powder, it can be used in all positions even for pipe welding, Electrodes with other than low-hydrogen coverings may produce "hydrogen-induced cracking" in those steels., along with good Weld ability, machinability, and corrosion resistance. The fillet welds made in the horizontal and flat welding positions have a slightly convex weld face, with a smooth and finely rippled surface. These electrodes are characterized by a smooth, quiet arc, very low spatter, and medium arc penetration. it gives X-ray quality welds.

Typical Application

SME 7018 Joining steels like ASTM SA 414, ASTM 333, IS 2002, IS 2041, Boiler, Pressure Vessels, Petrochemical Refinery Equipment's, Storage Tanks and Pipes, SM E7018 electrodes are used for joints involving high-strength, high carbon, or low-alloy steels.

Mechanical Properties

Tensile Strength Min : 490 Mpa, Yield Strength Min : 400 MPa, Elongation Min : 22 % CVN impact at -30°C , 27 J Min

Weld Metal Chemistry (wt %)

С	Cr	Ni	Мо	Mn	Si	V	Р	S
0.15 max	0.2 max	0.30	0.30 max	1.60 max	0.75 max	0.08 max	0.035 max	0.035 max

Welding Current : AC, DCEP

Size (Ø mm)/Length	:	2.5.0	3.15	4.00	5.00
Current (amps)	:	80 - 120	100 - 140	140 - 180	180 - 220

Re Drying Conditions

To obtain best results Re-dry the electrodes at 400 °C for 1hour (Optionally available in vacuum – packed condition, Re-drying not required in this packaging.)

Note to Usage

Clean welding area by wire brush, To obtain best results Re-back the Electrodes at 350 - 400 °C for 1hour and keep it at 100 - 150 °C Prior to use.

