

S-7018.G

TYPE : Basic

AWS A5.1 / ASME SFA5.1 E7018
JIS Z3211 E4918
EN ISO 2560-A - E42 3 B 3 2

Applications

S-7018.G can be used for highly efficient-welding of 490MPa(73,000lbs/in²) class high tensile steel, such as bridges, buildings, rolling stock and machines.

Characteristics on Usage

S-7018.G is an iron powder low hydrogen type electrode of high efficiency used for welding 490MPa(73,000lbs/in²) class high tensile steel.

Notes on Usage

- ① Dry the electrodes at 300~350°C(572~662°F) for 60 minutes before use.
- ② Keep the arc as short as possible.
- ③ Use wind screen against strong wind.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.06 | 0.50 | 1.20 | 0.017 | 0.011 |

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) |
|---------------------------------|---------------------------------|-----------|------------------|----------------------------------|
| 504 (73,200) | 572 (83,100) | 29.8 | -30 (-22) | 111 (82) |

Approval

KR, ABS, LR, BV, DNV, GL, NK, NAKS

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

| Size 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) |
| | - | 400 (16) | 450 (18) | 450 (18) | |
| F | 60~90 | 90~140 | 130~190 | 180~240 | 250~300 |
| V-up, OH | 50~80 | 80~120 | 120~170 | 150~200 | - |