

Basic 7018

CLASSIFICATION

AWS A5.1	E7018 H4	A-Nr	1
ISO 2560-A	E 42 4 B 4 2 H5	F-Nr	4
		9606 FM	1

GENERAL DESCRIPTION

Electrode producing crack-free welded joints with good toughness properties even on steels with a carbon content up to 0,4 %.
Recovery 120%

Excellent weldability even in positional welding

Good impact values down to -40°C

Suitable for depositing buffer layers on steels having a higher carbon content

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CURRENT TYPE

DC +

APPROVALS

BV	DNV	LR	DB	GL	TÜV
3YH5	3YH5	3YH10	+	3YH5	+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	HDM
0.05	1.3	0.4	4 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
					-40°C	-46°C
Required: AWS A5.1		min. 400	min. 490	min. 22		min. 27
ISO 2560-A		min. 420	500-640	min. 20	min. 47	
Typical values	AW	475	540	27	105	50

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	3.2	4.0	4.0	5.0
	Length (mm)	350	350	450	350	450	450
Carton + PE foil	Pieces / unit	205	125	125	85	85	55
	Net weight/unit (kg)	4.6	4.5	5.9	4.6	6.0	5.8

Identification Imprint: 7018 / BASIC 7018

Tip Color: none

Basic 7018: rev. C-EN02-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to EH36
Cast steels	
EN 10213-2	GP240R
Pipe material	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415, L445
API 5LX	X42, X46, X52, X60
EN 10216-1	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3	S275, S355, S420
EN 10025 part 4	S275, S355, S420

REMARKS / APPLICATION ADVICE

Redry electrodes 2-4h 350 ±25°C after removal from cardboard boxes