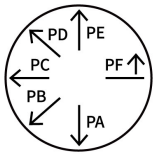


S-7018.G

Classification

- AWS** A5.1/ASME SFA-5.1 E7018
- JIS** Z 3211 E4918
- EN** ISO 2560-A E42 3 B 1 2
- KS** D7006 E5016

Welding Positions



Features

- Suitable for butt and fillet welding of heavy structure
- Good crack resistance and X-ray performance-
- Good mechanical properties
- Iron powder and low hydrogen type electrode (high efficiency)

Polarity

AC or DC +

Application Areas

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	NK	CWB	CE	DB	TUV
✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.06	0.32	1.01	0.017	0.008

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
445(64)	532(77)	30	-30(-20)	111(82)

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	60-90	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)/400(16)	90-140	80-120	
4.0(5/32)	400(16)/450(18)	130-190	120-170	
5.0(3/16)	400(16)/450(18)	180-240	150-200	
6.0(15/64)	450(18)	250-310	-	

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux