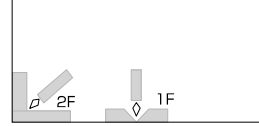


## Stick electrode

## Features:

- Suitable for flat and horizontal fillet welding
- Iron powder low hydrogen type

## Welding Positions:



**Classification:** AWS A5.1 E7018

**Redrying Conditions:** 300~350°Cx0.5~1h

**Identification color:** 1st Silver, 2nd Orange

**Polarity:** AC, DCEP

## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
6.0	550	5	20	210	170W, 75H, 580L
6.4	700	10	20	295	170W, 65H, 730L
8.0	450, 550, 700	5, 10	20	268, 327, 416	170W, 80~115H, 480~730L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.11	0.15
<b>Si</b>	0.40	0.75
<b>Mn</b>	1.12	1.60
<b>P</b>	0.014	0.035
<b>S</b>	0.004	0.035
<b>Ni</b>	0.02	0.30
<b>Cr</b>	0.03	0.20
<b>Mo</b>	<0.01	0.30
<b>V</b>	0.01	0.08
<b>Others<sup>b</sup></b>	1.18	1.75

Note: <sup>a</sup> Single values are maximum.

<sup>b</sup> Combined Limit for Mn+Ni+Cr+Mo+V

## Welding parameters (A)

φ mm	1F, 2F
6.0	250~300
6.4	270~320
8.0	350~400

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	480	400min.
<b>TS (MPa)</b>	550	483min.
<b>EI on 4d (%)</b>	30	22min.
<b>IV -29°C (J)</b>	74	27min.

## Approvals

<b>ABS</b>	3, 3Y, H10
<b>LR</b>	3Ym, 3YG, H15
<b>DNV-GL</b>	3Y, H15
<b>BV</b>	3, 3Y, H10
<b>NK<sup>a)</sup></b>	KMW53, H10

Note: <sup>a)</sup> AC