

Stick electrode

Features: ■ Suitable for low temperature service steel

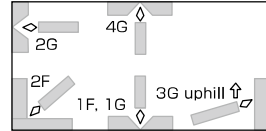
Classification: AWS A5.1 E7018-1

Redrying Conditions: 350~400°Cx1h

Identification color: 1st Brown, 2nd White

Polarity: AC, DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	23	170W, 105H, 380L
3.2	350	5	20	35	170W, 105H, 380L
4.0	400	5	20	61	170W, 105H, 430L
4.0	450	5	20	69	170W, 100H, 480L
5.0	450	5	20	106	170W, 110H, 480L

Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty ^a
C	0.08	0.15
Si	0.37	0.75
Mn	1.53	1.60
P	0.012	0.035
S	0.003	0.035
Ni	0.01	0.30
Cr	0.03	0.20
Mo	0.01	0.30
V	<0.01	0.08
Ti	0.025	-
B	0.0045	-
Others^b	1.58	1.75

Note: ^a Single values are maximum.

^b Combined Limit for Mn+Ni+Cr+Mo+V

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	70~100	65~95
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	-

All-weld mechanical properties

	Typical (DCEP)	Guaranty
0.2%YS (MPa)	490	400min.
TS (MPa)	580	483min.
EI on 4d (%)	31	22min.
IV -46°C (J)	135	27min.

Approvals

ABS	4Y400, H10
LR	4Y40m H10