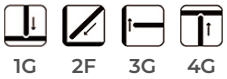
# S-7018.A1

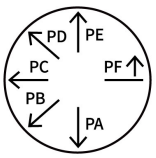


## Classification

AWS A5.5/ASME SFA-5.5 E7018-A1
JIS Z 3223 E4918-1M3
EN ISO 3580-A E Mo B 3 2

## Welding Positions




## Features

- Good mechanical properties
- Good bead appearance
- Iron powder type electrode (high efficiency)

## Polarity

AC, DC ±

## Application Areas

- Low alloy steel (0.5% Mo)
- Pressure vessels

## Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

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

| C | Si | Mn | P | S | Mo |
|---|---|---|---|---|---|
| 0.05 | 0.65 | 0.70 | 0.016 | 0.007 | 0.51 |

## Typical Mechanical Properties of All-Weld Metal

| PWHT | Yield Strength MPa(ksi) | Tensile Strength MPa(ksi) | Elongation (%) |
|---|---|---|---|
| 620°C*1hr | 525(76) | 627(91) | 31 |

## Diameter / Welding Parameters / Packaging

| Diameter mm(in) | Length mm(in) | F & HF | V-up, OH | Packaging |
|---|---|---|---|---|
| 2.6 (3/32) | 350 (14) | 55~90 | 50~80 | Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs) |
| 3.2 (1/8) | 350 (14) | 90~130 | 80~120 | |
| 4.0 (5/32) | 400 (16) | 130~190 | 120~170 | |
| 5.0 (3/16) | 400 (16) | 190~240 | - | |
| 6.0 (15/64) | 450 (18) | 250~300 | - | |