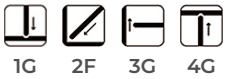
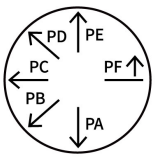
S-7018.W

Classification

AWS A5.5/ASME SFA-5.5 E7018-W1
JIS Z 3214 DA5026G
EN ISO 2560-A E42 2 B 3 2

Welding Positions





Features

- Suitable for off- and on-shore construction
- High resistance to corrosion caused by seawater or combinations of oil, gas and seawater
- Contains Cu, Ni and Cr (All-weld metal)

Polarity

AC or DC +

Application Areas

- High tensile weathering steel

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	Cu	Ni	Cr
0.06	0.54	0.65	0.014	0.006	0.36	0.23	0.24

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
505(73)	573(83)	26	-20(0)	100(74)

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)	90-140	80-120	
4.0(5/32)	400(16)	130-190	110-170	
5.0(3/16)	400(16)	180-240	150-200	
6.0(15/64)	450(18)	250-300	-	