SUNTHERM 7018-1

Low Hydrogen Electrode

CLASSIFICATION

IS 814-04 : EB5626H3JX
AWS/A 5.1 : E 7018- 1

CHARACTERISTICS

SUNTHERM 7018-1 is a low hydrogen iron powder electrode giving exceptionally tough and ductile welds. Metal recovery is approximately 115%. Typical hydrogen content in weld metal is 3.6ml/100 grams and also rovides high Impact strength at down to minus 46°C.

APPLICATIONS

Pressure Vessels, Heavy and Rigid structure, Equipments require heavy impact at minus 46°C, Thick plates of Carbon Steel, Boilers.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.076	1.40	0.49	0.019	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	CVN Impact Values at minus 46°C
468.0 N/mm^2	584.0 N/mm^2	26.40%	69.6%	50 Joules avg

PACKING DATA:

Size (mm)	Length (mm)	Current (Amp) AC 70 V or DC (+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard Box
2.50	350	60-90	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg
6.30	450	240-300	5 Kg	20 Kg

RECOMMENDATIONS:

Ready the electrodes at 350°C for one hour or at 250°C for two hours. Use short arc to get to optimum results.