

SUNTHERM 7018-A1

Low Hydrogen Electrode



CLASSIFICATION

IS 814-04 : E49B-A1-26Fe
AWS/A 5.5 : E 7018-A1

CHARACTERISTICS

An outstanding hydrogen controlled electrode for welding of 0.5% Mo steels and other low alloy steels subjected to elevated temperature up to 525 C. Welds are of radiographic quality. Coating is especially formulated to resist moisture pick up under condition of high humidity. It has good slag detachability and a high operator appeal. Metal recovery is minimum 110%.

APPLICATIONS

Elevated temperature service up to 525°C, Pressure vessels, Tubes, Boilers, Pipes etc.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Molybdenum	Sulphur	Phosphorus
0.075	1.45	0.47	0.52	0.019	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation
472.0 N/mm ²	576.0 N/mm ²	26.80%

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:

Use stringer bead technique and lower currents to ensure proper alloy transfer. Re-dry the electrodes at 350°C for one hour or 250°C for two hours. Maintain interpass temperature around 100°C