

# S-7018.A1

Type : Basic

## Conformances

AWS A5.5/ ASME SFA5.5 E7018-A1

JIS Z3223 E4918-1M3

EN 1599 - EMo B 3 2

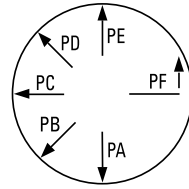
## Applications

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

## Features

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

## Welding Position



## Current

AC, DC ±

## Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

## Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

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

C	Si	Mn	P	S	Mo
0.07	0.77	0.88	0.018	0.010	0.52

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Heat Treatment
477 (69,300)	617 (89,600)	32.8	620°C(1148°F) X 1hr. S.R

## Typical Welding Parameters / Amp.(A)

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