S-7018.W

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E7018-W1
JIS Z3214 DA5026G
EN ISO 2560-A - E42 2 B 3 2

Applications

S-7018.W can be used for welding of carbon and high tensile weather proof steel.

Characteristics on Usage

S-7018.W is an iron powder, low hydrogen type electrode for all position welding.
It shows high resistibility to the atmospheric corrosion, since its all weld metal contains Cu, Ni, Cr.
Crack resistibility and mechanical properties are good.

Notes on Usage

① Dry the electrodes at 350~400℃(662~752℉) for 60 minutes before use.
② Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose because arc striking on the base metal is in danger of initiating cracking.
③ Preheat at 80~100℃(176~212℉)before use. The temperature to be applied varies in accordance with plate thickness and steel kind.

Welding Position

1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Cr	Cu
0.05	0.56	0.62	0.015	0.013	0.23	0.24	0.37

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
505 (73,300)	573 (83,200)	31.3	-20 (-4)	100 (74)

Approval

I Packing

Packet 5 ㎏ (11 lbs)
Carton 5 ㎏ (11 lbs)×4 : 20㎏(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size 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	60~90	90~140	130~190	180~240	250~300
V-up, OH	50~80	80~120	120~170	150~200	-