

Applications

S-7018.A1 can be used for welding of 0.5%Mo heat resistant steel used for high temperature and high pressure boilers, chemical industries, oil refining industries and turbine casting. Other general low alloy steel and high tensile steel.

Characteristics on Usage

S-7018.A1 is an iron powder low hydrogen type electrode. Its coating contains much iron powder, which increasing working efficiency.

Notes on Usage

- ① Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ② Preheat at 100~200°C(212~392°F) and postheat at 620~680°C(1148~1256°F).
- ③ Keep the arc as short as possible.

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	Mo
0.07	0.77	0.88	0.018	0.010	0.52

Typical Mechanical Properties of All-Weld Metal

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

Approval

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs)×4 : 20kg(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	55~90	90~130	130~185	190~250	250~300
V-up, OH	50~80	80~120	120~170	-	-