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# TECHNICAL DATA SHEET
# TECHWELD E7018

## CLASSIFICATION

| AWS A 5.1 | IS 814 | BS 639 | DIN 1913 |
|---|---|---|---|
| E7018 | EB 5426$H_3$JX | E 5144B12024(H) | E 5144B1026 |

## CHARACTERISTICS

The electrode has basic heavy coated low hydrogen with iron powder compound which permits deposition efficiency of 115% approx. It gives stable arc, low spatter, and smooth weld beads with easily detachable slag. The weld metal is radiographic quality with excellent mechanical properties even at sub-zero temperatures. The electrodes are easy to operate in all positions.

## APPLICATIONS

This type of electrode are widely used for heavy restrained joints subject to dynamic loading, boilers, pressure vessels, bridges, earth moving equipment, blast furnace shells, pipelines and heavy structures, ship plates boilers etc.

**Note:** Store the Electrode at dry place, Re dry the electrode at 300°C for one hour before use. Clean the weld area thoroughly, free of any contamination.

## WELDING POSITION


## TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL

| ELEMENT | C | Mn | Si | S | P |
|---|---|---|---|---|---|
| PERCENT (max) : | 0.08 | 1.10 - 1.60 | 0.40 | 0.025 | 0.025 |

## TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

| YS (N/mm²) | UTS (N/mm²) | Elongation in % | CVN Impact at -30°C (Joules) |
|---|---|---|---|
| 450 - 510 | 510 - 580 | 25 - 30 | 80 - 150 |

## CURRENT CONDITION : AC (OCV-70V) / DC (+)

| SIZE(mm) | Ø 2.50 | Ø 3.20 | Ø 4.00 | Ø 5.00 |
|---|---|---|---|---|
| CURRENT (amps) | 60 - 90 | 100 - 140 | 150 - 190 | 180 - 240 |

## PACKING DETAILS

| DIA (mm) | Ø 2.50 | Ø 3.20 | Ø 4.00 | Ø 5.00 |
|---|---|---|---|---|
| LENGTH (mm) | 350 | 350/450 | 450 | 450 |
| WEIGHT /PKT (Kg) | 2 | 2 | 2 | 2 |
| PKT / BOX | 10 | 10 | 10 | 10 |
| WEIGHT /BOX (Kg) | 20 | 20 | 20 | 20 |