

Basic 7018

CLASSIFICATION

AWS A5.1 : E7018 H4
ISO 2560-A : E 42 4 B 42 H5

GENERAL DESCRIPTION

Electrode producing crack-free welded joints with good toughness properties even on steels with a carbon content up to 0,4 %.
Recovery 120%
Excellent weldability even in positional welding
Good impact values down to -40°C
Suitable for depositing buffer layers on steels having a higher carbon content

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CURRENT TYPE

DC +

APPROVALS

BV	DNV	LR	DB	GL	TÜV
3YH5	3YH5	3YH10	+	3YH5	+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	HDM
0.05	1.3	0.4	4 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
					-40°C	-46°C
Required: AWS A5.1 ISO 2560-A Typical values	AW	min. 400 min. 420 475	min. 490 500-640 540	min. 22 min. 20 27	min. 47 105	min. 27 50

PACKAGING AND AVAILABLE SIZES

Unit: Carton + PE foil	Diameter (mm)	2.5	3.2	3.2	4.0	4.0	5.0
	Length (mm)	350	350	450	350	450	450
Pieces / unit	205	125	125	85	85	55	
Net weight/unit (kg)	4.6	4.5	5.9	4.6	6.0	5.8	

Identification Imprint: 7018 / BASIC 7018

Tip Color: none

Basic 7018: rev. EN 02

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to EH36
Cast steels	
EN 10213-2	GP240R
Pipe material	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415, L445
API 5LX	X42, X46, X52, X60
EN 10216-1	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
Boiler & pressure vessel steel	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3	S275, S355, S420
EN 10025 part 4	S275, S355, S420

REMARKS / APPLICATION ADVICE

Electrodes after removal from cardboard boxes redry 2-4h 350 ± 25°C