MMA COATED ELECTRODES

UNIVERSAL BASIC (7018)

NON-ALLOY STEELS

INVEST IN THE FUTURE

Basic universal electrode for welding highly stressed steel assemblies (carbon and carbon manganese, tensile strength up to 560 MPa). It's mechanical properties are excellent, especially at low temperatures.

Classification

EN ISO 2560-A : E 42 4 B 4 2 H5
AWS A 5.1 : E 7018-1

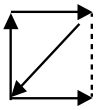
Applications

- Pipework,
- Pressurised tanks,
- Shipyards,
- Offshore oil platforms,
- High quality steel constructions.

Benefits

- Excellent mechanical properties.
- Low hydrogen concentration.

Positions and polarity



- Ignition from 70V - Direct current.
- **Electrode polarity : (+) for thin sheets/ penetration and (-) for filling.**

Chemical properties

C %	Mn %	Si %	S %	P %
0.05	1.40	0.40	0.020	0.015

Mechanical properties

Re	Rm	A 5 d	KV -40 °C
470 MPa	560 MPa	26%	60 J

Recommendations

Ø électrode (mm)	2.0	2.5	3.2	4.0
thickness (mm)	1,5 ▶ 3	2,5 ▶ 6	5 ▶ 8	8 ▶ +
welding current (A)	20 ▶ 50	60 ▶ 110	90 ▶ 140	130 ▶ 190

Approval

TÜV - RINA - ABS - LRS - DNV

Packaging

		(2 kg) SOUS VIDE	Ø (mm)	length (mm)	x...
A	066717		Ø 2.0	300	13
A	066724		Ø 2.5	350	10
B	081918		Ø 2.5	350	210
B		081970			84
A	066731		Ø 3.2	350	7
B	081925		Ø 3.2	350	130
B		081987			54
A	066748		Ø 4.0	350	6
B	081932		Ø 4.0	350	96
B		081994			38