

BASIC 7018

TOP FEATURES

- Recovery 120%
- Excellent weldability even in positional welding
- Good impact values down to -40°C

CLASSIFICATION

AWS A5.1 E 7018
EN ISO 2560-A E 42 4 B 42 H5

CURRENT TYPE

DC+; DC-

WELDING POSITIONS

All position, except vertical down

APPROVALS

LR	BV	DNV	TÜV	DB
+	+	+	+	+

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

C	Mn	Si	P	S	HDM
0.08	1.1	0.45	≤ 0.025	≤ 0.015	4 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
Required: AWS A5.1		min. 400	min. 490	min. 22	
EN ISO		min. 420	500-640	min. 20	min. 47
Typical values	AW	≥ 430	510-610	≥ 24	≥ 70
	600°Cx1h	≥ 420	500-600	≥ 22	≥ 70

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	65-90
3.2x350	120-140
3.2x450	120-140
4.0x350	160-190
4.0x450	160-190
5.0x450	210-230

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	CBOX	180	4.0	588655-1
3.2x350	CBOX	112	4.0	588656-1
3.2x450	CBOX	117	5.5	588657-1
4.0x350	CBOX	79	4.0	588658-1
4.0x450	CBOX	81	5.5	588659-1
5.0x450	CBOX	55	5.5	588660-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.