

ROYAL 7018 G (E 7018 G)

AWS : SFA 5.5, E 7018 G EN ISO 2560 A E 42 5 Z B 32 H5

Applications

Welding of high strength steel, heavy duty structural fabrication, fine grained, Q & T steel, pressure vessels, tanks, Penstocks.

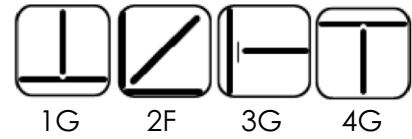
Characteristics on Usage

A basic coated low hydrogen iron powder type electrode. it is used for welding heavy section of fine grained, high strength steel. It's running very smooth and easy slag removable, yielding a weld deposit containing 1.50%Mn and 0.7%Ni. it gives radiographic quality and low temperature service down to minus 60°C.

Notes On Usage

- ☞ Dry the electrodes at 250 - 350°C for 60 min before use.
- ☞ Keep the arc as short as possible .
- ☞ Adopt back step method or strike the arc on a small plate prepared for this particular purpose because ar striking o the base metal is in danger of initing cracking.

Welding Positions



Approvals

E.I.L

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni%
0.090 Max	1.60 Max	0.30 Max	0.030 Max	0.030 Max	1.50 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 50° C (J)	Hydrogen (Mercury method) in 100gm weld metal
520 Mn	450 Min	22 % Min	40 Joules Min	5 ml (Max)

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	70 - 90
3.15 x 450	5	20		90 - 130
4.00 x 450	5	20		140 - 180
5.00 x 450	5	20		180 - 230