

FEREX 7018 LT

A basic coated low hydrogen electrode combining good all positional running characteristics with consistent weld metal properties down to -30 deg.c. DC- is preferred.

Specifications

Classifications	SFA/AWS A5.1 : E7018 EN ISO 2560-A : E 42 4 B 32 H 5
Approvals	ABS : 3YH5 BV : 3Y H15 CE : EN 13479 DNV-GL : 3YH5 LR : 3YH15 UKCA : EN 13479 VdTÜV : 03862

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC-(+)
Diffusible Hydrogen	Max 5 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	490 MPa	575 MPa	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	70 J

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	75-110 A	23 V	64 %	59 sec	1.0 kg/h
3.2 x 450.0 mm	90-155 A	25 V	67 %	92 sec	1.5 kg/h
4.0 x 450.0 mm	125-200 A	26 V	68 %	101 sec	2.0 kg/h
5.0 x 450.0 mm	190-260 A	26 V	72 %	106 sec	2.8 kg/h