

Fortrex 7018

A basic coated hydrogen controlled electrode designed for all positional welding (except vertical down) of carbon and medium tensile steels and mild steels under conditions of high restraint. The electrode is intended for general fabrication work where hydrogen control is required - this electrode guarantees values below H4. An iron powder addition is included in the coating, this gives a weld metal recovery of approximately 120%. Striking and re-striking qualities are good and slag is easily removed from the weld.

Specifications

Classifications	SFA/AWS A5.1 : E7018 H4R EN ISO 2560-A : E 42 4 B 42 H5
Approvals	ABS : 3Y H5 BV : 3Y H5 CE : EN 13479 DNV : 3 YH5 LR : 3Y H5 UKCA : EN 13479

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

Welding Current	DC+-
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Carbon Manganese.
Coating Type	Basic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	445 MPa	540 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	80 J

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90° I max	Deposition Rate
2.5 x 350.0 mm	70-110 A	24 V	67 %	57 sec	0.96 kg/h
3.2 x 450.0 mm	90-140 A	23 V	73 %	85 sec	1.33 kg/h
4.0 x 450.0 mm	120-190 A	24 V	71 %	92 sec	1.76 kg/h
5.0 x 450.0 mm	190-260 A	24 V	75 %	99 sec	2.61 kg/h