

Basic

WE 7018



EN ISO 2560-A :	E 42 4 B 42 H10	AWS A 5.1 :	E 7018	EN 499 :	E 42 4 B 42 H10
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DESCRIPTION AND USAGE:

Thick coated basic MMA electrodes used for welding highly strained components with static and dynamic loadings. It is used for structures used down to -40° C. It is recommended for the following types of steel:

- S235JR - S355JR, S235JO - S355JO, S235J2 - S355J2, S275N - S420N, S275M - S420M, S275NL - S420NL, S275ML - S420ML
- P235GH - P355GH, P275NL1 - P355NL1, P275NL2 - P355NL2, P215NL, P265NL, P355N, P285NH - P420NH, P195TR1 - P265TR1, P195TR2 - P265TR2, P195GH - P265GH
- L245NB, L415NB, L245MB - L415MB, GE200 - GE240, GE300, shipbuilding steels: A, B, D, E, A 32-F 36, A 40-F40
- ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1, LF2; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr 58, 65, 70; A 588 Gr. A, B; A 633 Gr. A, C, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 711 Gr. 1013; A 841 Gr. A, B, C;
- API 5 L Gr. B, X42, X52, X56, X60

CHEMICAL COMPOSITION OF WELD METAL:

C %	Mn %	Si %	P %	S %
max. 0,10	0,80-1,20	0,20-0,65	max. 0,025	max. 0,025

MECHANICAL PROPERTIES OF WELD METAL :

Yield strength N/mm ²	Tensile strength N/mm ²	Elongation A 5d %	Impact Energy Kv J	
			+20°C	-40°C
430-490	510-550	min. 24	min. 140	min. 47

WELDING BEHAVIOUR :

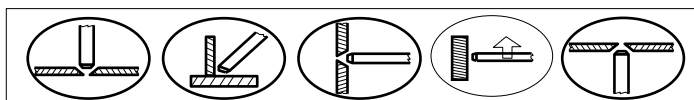
Welds with a stable arc, almost without spatter, the slag is very easy to remove. Weld metal recovery is about 116%.

WELDING AND PACKAGING DATA :

DIAMETER mm	LENGTH mm	WELDING CURRENT A	Kg/BOX Kg
2,5	[300] 350	65 - 90	5,0
3,25	[350] 450	120 - 140	5,0
4,0	[350] 450	160 - 190	5,0
5,0	450	210 - 230	5,0

DC+ CURRENT

WELDING POSITIONS :



IMPORTANT :

Before welding redry the electrodes at 300 - 350°C for 2 hours.