

Applications

S-7018.1 can be used for welding of high tensile steel, such as bridges, rolling stock and low temperature used for steel structures.

Characteristics on Usage

S-7018.1 is an iron powder low hydrogen type electrode of high efficiency used for welding of high tensile steel. Its usability is good with direct current applications as well as alternation current applications and easy to weld in all position.

Notes on Usage

- ① Dry the electrodes at 350~400°C(622~752°F) for 60 minutes before use.
- ② Keep the arc as short as possible, and avoid large width of weaving.
- ③ Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.25	1.25	0.017	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
480 (69,700)	550 (79,800)	30.2	-45 (-49)	94 (70)

Approval

ABS, BV, LR, DNV, GL, RINA

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	400 (16)	450 (18)	450 (18)	450 (18)
F	60~90	90~140	130~190	180~240	250~300
V-up, OH	50~80	80~120	120~170	150~200	-