

ES 7018-A1

SMAW

ESWECO
The Art of Welding

Type Lime-basic

E7018-A1

Description

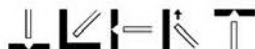
ES 7018-A1 is an LMA electrode alloyed with 0.5%Mo for welding steels for pressure vessels. The running characteristics make it suitable for welding joints in inclined positions. The composition of the coating is adapted for welding with low currents, making ES 7018-A1 very suitable for the welding of pipes.

Recovery

115%

Current

AC, DC+ OCV 65 V



Classifications

SFA/AWS A5.5	E7018-A1
EN 1599	E Mo B 42 H5
ISO 3580	E Mo B 20

Typical all weld metal composition, %

C	Si	Mn	Mo
0.06	0.5	0.7	0.5

Typical mech. Properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	560
Elongation, %	27

Charpy V

Test temps, °C	Impact values, J
+20	175
0	>31

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	75-110	23
3.2	350	105-150	23
3.2	450	105-150	25
4.0	450	140-200	26