


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA SPEEDARC 7018-G-E	
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CLASSIFICATION

ASME IIC SFA 5.5 / AWS A 5.5: E7018-G
EN ISO 2560-A: E 50 6 Mn1Ni B 3 2 H5

DESCRIPTION

- Basic coated SMAW electrode for all position welding with high level mechanical properties
- Welding of steels subject to high static or dynamic stresses with guaranteed high toughness even at low temperatures
- Excellent usability in all positions, stable arc, soft fusion, very high radiographic quality
- Low hydrogen content

APPLICATIONS

Base materials

Construction steel, boiler plate, pipe steels, fine-grained steels, shipbuilding steels, cast steels with a yield strength up to 500 MPa where good impact toughness is required down to - 60°C

Examples

Construction steels	EN 10025	S235JR to S355K2G4
Fine-grained steels	EN 10028-3	P275N, NH, NL1, NL2 to P460N, NH, NL1, NL2
	EN 10113	S275N to S460N, S275M to S460ML
Pressure vessel steels	EN 10028-2	P235GH to P355GH
Pipe steels	EN 10208	L240NB to L485MB
	API 5LX	X42, X46, X 52, X60, X65, X70
Shipbuilding steels	A, B, D, E, A32/36	to F40
	ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1	

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Ni
0.05	1.5	0.4	0.9

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
550	450	20	-60°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
650	560	28	-60°C: 60

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350/450	4.0 x 450	5.0 x 450
Current [A]	60 - 90	90 - 135	130 - 180	170 - 230
= +/-	~ 70V			

Re-drying if standard packaging: 2 hours at 350° C
Recovery: 120 %

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PD, PE, PF
ASME IX: 1F, 1G, 2F, 2G, 3Fu, 3Gu, 4F, 4G, 5Gu

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350/450	4.0 x 450	5.0 x 450
Weight/box [kg]	5	5	5	5

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.