

S-7018.GH

TYPE : Basic

AWS A5.1 / ASME SFA5.1 E7018
JIS Z3211 E4918
EN ISO 2560-A - E42 3 B 3 2 H5

SMW

Applications

S-7018.GH can be used for highly efficient-welding of 490MPa (73,000lbs/in²) class high tensile steel, such as bridges, buildings, rolling stock and machines.

Characteristics on Usage

S-7018.GH is an iron powder very low hydrogen type electrode of high efficiency used for welding 490N/mm² (73,000lbs/in²) class high tensile steel. (HDM < 5mℓ/100g)

Notes on Usage

- ① Dry the electrodes at 300~350°C (572~662°F) for 60 minutes before use.
- ② Keep the arc as short as possible.
- ③ Use wind screen against strong wind.

Welding Position



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

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.07	0.42	1.21	0.018	0.006

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)
488 (70,800)	566 (82,100)	27.4	-30 (-22)	126 (93)

Approval

CWB

I Packing

Packet	5 kg (11 lbs)
Carton	5 kg (11 lbs) × 4 : 20kg(44 lbs)
Vacuum Pack	5 kg (11 lbs)
Carton	5 kg (11 lbs) × 4 : 20kg(44 lbs)
Vacuum Pack	1.5 kg (3.3 lbs)
Carton	1.5 kg (3.3 lbs) × 10 : 15kg (33 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)	350 (14)	400 (16)	400 (16)	450(18)
	-	400 (16)	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	-