

AK E7018-1

Description: Basic coated electrode designed for high quality welding. Excellent strength and toughness properties. It is also suitable for welding steels with low purity and high carbon content.

Application: For welding of steel structures, boiler and vessel construction, vehicle construction, shipbuilding and machinery construction and buffer layer when constructed on high carbon steel.

Typical Chemical Composition(%):

	C	Mn	Si	P	S	Cr	Ni	Mo	V
Requirement	0.15	1.6	0.75	0.035	0.035	0.20	0.30	0.30	0.08
Actual Result	0.06	1.3	0.30	0.025	0.025	0.03	0.01	0.006	0.01

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥430	≥ 24	≥47J(-50℃)
Actual Result	586	472	28	110

Recommended welding parameters

2.5	3.2	4.0	5.0
DC+	DC+	DC+	DC+
65-95	100- 135	110- 210	170-240