

AK E7018

Description: AK-E7018 is an alkaline, iron powder carbon steel electrode designed for all positional welding. With suitable welding properties like low spatter, good slag removal, easy arc strike, and restrike, good looking weld clearance, etc. Excellent mechanical performance and crack resistance.

Application: Used to weld the Marine steel (A 、 B 、 D 、 E 、 AH36 、 DH36 、 EH36) and the same grade strength low carbon steel structures, like Boilers, Pressure Vessels and Offshore drilling platforms, etc..

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	V
Requirement	0.15	0.9	1.60	0.035	0.035	0.30	0.30	0.20	0.08
Actual Result	0.072	0.52	1.26	0.012	0.017	0.008	0.030	0.027	0.017

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥490	≥400	≥ 17	≥47J(-30℃)
Actual Result	550	440	28	150

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current / A	F/ H	70-110	100-140	140-170
	V/OH	60-70	80- 110	130- 150