

Product Data Sheet



BRAND NAME VJ 7018C2L

AWS E7018-C2L

SPECIFICATION SFA 5.5

Features and Applications :

VJ 7018-C2L is a low hydrogen iron powder electrode depositing 3.5% Nickel in the weld metal. It operates smoothly in all positions and delivers radiographic quality welds with excellent toughness down to -101°C . Ideal for welding fine-grained and Nickel steels, it is widely used in pressure vessels, piping, valves, and tanks for liquefied gas applications.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.05
Mn	0.75
Si	0.30
S	0.025
P	0.03
Cr	3.50

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - PWHT 610°C-1 Hr	
Properties	Typical
YS (MPa)	435
UTS (MPa)	530
El (%)	30
Charpy V at -100°C (J)	45

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
2.50 x 350	70	100	150
3.15 x 450	90	140	100
4.00 x 450	140	190	70
5.00 x 450	190	250	45

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 2 hour.