

Product Data Sheet



BRAND NAME VJ 7018G

AWS E7018-G

SPECIFICATION SFA 5.5

Features and Applications :

VJ 7018G is a basic coated electrode with excellent welding characteristics, specifically designed for welding carbon steels and carbon manganese steels with elevated yield strength. A typical field of application is offshore construction. The weld metal, alloyed with up to 1% Ni, meets the impact toughness requirements at -50°C. The weld metal provides radiography quality.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.10
Mn	1.50
Si	0.60
S	0.030
P	0.030
NI	0.50-1.0

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
YS (MPa)	430
UTS (MPa)	530
EI (%)	26
Charpy V at -45°C (J)	52

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 1 hour.