

Product Data Sheet

BASIC COATED LOW HYDROGEN ELECTRODE FOR LOW TEMP. APPLICATION.

BRAND NAME VJ 7018 -1

AWS/ASME Class E 7018-1

SPECIFICATION SFA 5.1 E7018-1



Features and Applications :

VJ 7018-1 is a high-quality electrode, providing high deposition rate. It provides excellent welding pool control, minimal spatter level, good arc strike and easy slag removal. Particularly suitable for welding high strength low-alloy steels. Weld deposit is of Radiographic Quality with very Resistant to hot cracking and excellent Notch Toughness at sub zero temp.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.10
Mn	1.0 - 1.60
Si	0.75
S	0.030
P	0.030

MECHANICAL PROPERTIES OF WELD METAL

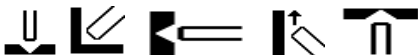
All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	480
UTS (MPa)	570
El (%)	29
Charpy V at -45°C (J)	110

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
2.50 x 350	60	90	150
3.15 x 450	90	140	100
4.00 x 450	150	190	70
5.00 x 450	200	260	45

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

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