

Product Data Sheet

BASIC COATED MOISTURE RESISTANT & LOW HYDROGEN ELECTRODE FOR LOW TEMP. APPLICATION.

BRAND NAME VJ 7018 -1 H4R

AWS/ASME Class E7018-1 H4R

SPECIFICATION SFA 5.1



Features and Applications :

VJ 7018-1 H4R is a high-performance, moisture-resistant electrode for critical applications. It delivers tough, ductile, radiographic-quality welds with 110% metal recovery and excellent crack resistance. Ideal for boilers, pressure vessels, and dynamic load structures, it performs reliably in all positions, including sour gas environments. Vacuum-packed to eliminate redrying, it ensures durability and superior weld quality.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.10
Mn	1.40
Si	0.40
S	0.030
P	0.030

MECHANICAL PROPERTIES OF WELD METAL

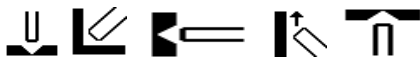
All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	450
UTS (MPa)	560
EI (%)	28
Charpy V at -45°C (J)	120

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:

DIFFUSIBLE HYDROGEN CONTENT: 4 ml / 100 gms of weld metal Max

MOISTURE AS CONDITIONED: 0.30 Max

Redrying: No need of redrying. The electrodes are vacuum packed.