Product Data Sheet

BASIC COATED LOW HYDROGEN ELECTRODE

BRAND NAME VJ 7018

AWS/ASME Class E 7018

SPECIFICATION SFA 5.1 EB 5426H3JX

Features and Applications :

VJ 7018 is a heavy-coated low-hydrogen electrode with a high percentage of iron powder, designed for welding in all positions. It provides tough, crack-resistant welds on mild and low alloy steels. VJ 7018 deposits high-quality welds that radiographic Quality. The electrode is engineered for high deposition efficiency, exceeding 110%, and features a thin, easily detachable slag with an excellent bead profile & extremely smooth and stable arc, with excellent arc striking and re-striking characteristics.

It is commonly applied in industries such as boilers, pressure vessels, atomic reactor shells, bridges, railway wagons and coaches, earth-moving equipment, pipelines, chemical industries, oil refineries.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	**Max**
C	0.10
Mn	0.80 - 1.60
Si	0.60
S	0.030
P	0.030

MECHANICAL PROPERTIES OF WELD METAL

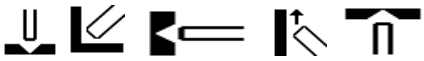
All Weld Metal - As Welded	
Properties	**Typical**
YS (MPa)	450-510
UTS (MPa)	510-580
El (%)	25-30
Charpy V at -30°C (J)	80-150

DIMENSIONS & CURRENT DATA

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

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 1 hour.