

Product Data Sheet

BASIC COATED MOISTURE RESISTANT & LOW HYDROGEN CONTROLLED ELECTRODE.

BRAND NAME VJ 7018 H4R

AWS/ASME Class E 7018-H4R

SPECIFICATION SFA 5.1



Features and Applications :

VJ 7018 H4R is a high-performance, moisture-resistant, hydrogen-controlled electrode. This heavy-coated, iron-powder electrode delivers 110% metal recovery, excellent mechanical properties, high ductility, crack resistance, and radiographic-quality welds—ideal for dynamic load applications. Vacuum-packed to eliminate redrying, it ensures clean, impurity-free welds with exceptional durability.

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

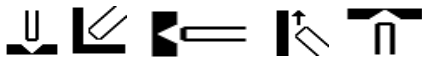
Diffusible Hydrogen < 4ml / 100gm weld metal

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
Dia x Length			
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: No need of redrying. The electrodes are vacuum packed.