

## Stick electrode

- Features:**
- Suitable for butt and fillet welding of heavy structure
  - Good performance by DCEP current

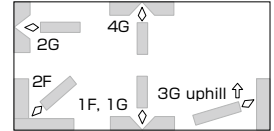
**Classification:** AWS A5.1 E7018

**Redrying Conditions:** 300~350°Cx0.5~1h

**Identification color:** 1st Blue white, 2nd Blue

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	24	170W, 105H, 380L
3.2	400	5	20	41	170W, 105H, 430L
4.0	450	5	20	69	170W, 105H, 480L
5.0	450	5	20	106	170W, 105H, 480L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.15
<b>Si</b>	0.59	0.75
<b>Mn</b>	0.97	1.60
<b>P</b>	0.013	0.035
<b>S</b>	0.007	0.035
<b>Ni</b>	0.02	0.30
<b>Cr</b>	0.03	0.20
<b>Mo</b>	<0.01	0.30
<b>V</b>	0.01	0.08
<b>Others<sup>b</sup></b>	1.03	1.75

Note: <sup>a</sup> Single values are maximum.

<sup>b</sup> Combined Limit for Mn+Ni+Cr+Mo+V

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	65~95	60~90
3.2	90~130	80~120
4.0	130~190	110~170
5.0	190~250	165~210

## All-weld mechanical properties

	Typical (AC)		Guaranty	
<b>0.2%YS (MPa)</b>	500	420	400min.	350min.
<b>TS (MPa)</b>	560	520	483min.	460min.
<b>El on 4d (%)</b>	31	32	22min.	25min.
<b>IV -29°C (J)</b>	110	140	27min.	27min.
<b>PWHT (°Cxh)</b>	AW	620x1	AW	620±15x1

## Approvals

<b>ABS</b>	3Y, H10
<b>LR</b>	3Ym, H15
<b>DNV</b>	3Y, H10
<b>NK</b>	KMW53, H10