

SUNTHERM 7018

Low Hydrogen Electrode



CLASSIFICATION

IS 1395-82 : E49B-G126
AWS/A 5.5 : E 7018
Approval : BIS, IBR, THERMAX

CHARACTERISTICS

SUNTHERM 7018 is a low hydrogen iron powder electrode suitable for welding of medium tensile strength steels. Radiographic quality welds, excellent ductility and notch toughness down to minus 30°C are some special features of this electrode. Metal recovery is minimum 110%. Typical hydrogen content is 3ml/100grams of weld deposit.

APPLICATIONS

Storage tanks, Dynamic loaded structure, Pressure Vessels, Boilers, Penstocks, Railway wagons, Blast furnace shells.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.075	1.24	0.47	0.019	0.020

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	Impact (CVN) at 0° C
468.0 N/mm ²	576.0 N/mm ²	26.80%	68%	62 Joules avg

PACKING DATA:

Size (mm)	Length (mm)	Current (Amp) AC 70 V or DC (+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard Box
2.50	350	60-90	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg
6.30	450	240-300	5 Kg	20 Kg

RECOMMENDATIONS:

Ready the electrodes at 350°C for one hour or at 250°C for two hours. Use short arc to get to optimum results.