

## Covered Low Hydrogen Electrode (SMAW)



ZUPERFAB 7018 is a basic coated, hydrogen controlled iron powder electrode designed for welding in all positions. It gives tough, crack resistant weld on mild and low alloy steels. It deposits good radiographic quality welds and is ideal for welding restraint structures where stresses can not be avoided.

<b>Classifications:</b>	SFA/AWS A5.1:E7018, EN ISO 2560-A:E 42 3 B 32 H5
<b>Approvals:</b>	DNV

<b>Welding Polarity:</b>	AC, DC+
<b>Diffusible Hydrogen:</b>	< 5.0 ml/100g
<b>Alloy Type:</b>	C-Mn
<b>Coating Type:</b>	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	470 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	-30 °C	100 J
As Welded	-40 °C	80 J

Typical Weld Metal Analysis %		
C	Mn	Si
0.08	1.20	0.40

Current Range	
Diameter	Current
2.5 x 350 mm	60-100 A
3.15 x 450 mm	80-130 A
4.0 x 450 mm	100-190 A
5.0 x 450 mm	180-260 A