

BASIC 7018P

TOP FEATURES

- High quality welding and 120% recovery deliver high productivity.
- Excellent weldability, suitable for positional welding.
- Good impact values down to -40°C.

CLASSIFICATION

AWS A5.1E7018 H4

EN ISO 2560-AE 42 4 B 4 2 H5

CURRENT TYPE

DC+; AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

DNV				
+				

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.06	1.5	0.3	≤0.025	≤0.025

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
Typical values	AW	≥430	490-550	≥24	≥47

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	100-140
3.2 x 450	100-140
4.0 x 350	140-190
4.0 x 450	140-190
5.0 x 450	190-250
5.0 x 450	190-250

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	185	4.1	629400
3.2 x 350	CBOX	120	4.2	629401
4.0 x 350	CBOX	85	4.3	629403
5.0 x 450	CBOX	55	5.5	629405

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.