SUPERCITO 7018S

TOP FEATURES

- Good welding characteristics, suitable for root passes and positional welding, welds are of X-ray quality.
- Very low diffusible hydrogen content, high impact toughness down to - 50°C.
- Efficiency 120%.
- DC and AC welding current.

CLASSIFICATION

AWS A5.1	E7018-1 H4
EN ISO 2560-A	E 42 5 B 32 H5

CURRENT TYPE

DC, AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	TÜV	DB
+	+	+	+	+

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

C	Mn	Si	P	S
0.05	1.2	0.4	≤0.020	≤0.015

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -47/-50°C
AWS A5.1	AW	≥400	≥490	≥22	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	485	560	28	150

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 350	100-135
3.2 x 450	85-135
4.0 x 450	110-210
5.0 x 450	170-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	90	1.9	W000258282
	CBOX	195	4.2	W000258277
3.2 x 350	VPMD	54	1.9	W000258283
	CBOX	119	4.2	W000258278
3.2 x 450	VPMD	54	2.4	W000258284
	CBOX	117	5.3	W000258279
4.0 x 450	VPMD	40	2.7	W000258285
	CBOX	85	5.7	W000258280

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.