

HYROD 7018LT

TOP FEATURES

- The weld metal diffusible hydrogen content conforms to low hydrogen, < 5 ml/100g deposited weld metal.
- Impact toughness down to - 40 °C.
- Weld metal recovery:~120%.

CLASSIFICATION

AWS	E7018-1 H4R
EN ISO 2560-A	E 46 4 B 32 H5

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

C	Mn	Si	P	S	HDM
0.06	1.4	0.3	0.015	0.010	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-20 °C	-50 °C	-46 °/-50 °C
Required: AWS A5.1		min. 400	min. 490	min. 22			min. 27
EN ISO		min. 460	530-680	min. 20		min. 47	
Typical values	AW	480	580	28	200	170	100

AW = As welded

Suitable for both As Welded and Stress Relieve (PWHT) conditions

CTOD value at -10°C > 0.25mm

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3,2x450	80-130
4,0x450	120-160

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Pieces / unit	Weight (kg)	Item number
3.2x450	CBOX	108	5.2	597523-1
4.0x450	CBOX	80	5.6	597530-1

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.

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