



Selectarc B7018S

Universal Basic Electrode

Classification

AWS A5.1 : E7018-1 EN 499 : E 46 4 B 3 2 H5
 AWS A5.1M : E 49 18 – H4 ISO 2560-A : E 46 4 B 3 2 H5

Description & Applications

Universal basic coated electrode (115% recovery) for welding highly stressed connections with high security. Good low temperature properties down to -40 °C. Resistant to cold cracks. Stable arc, slag easy to remove. For frames, cases, supports, ship building, pressure vessels.

Base materials

Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

EN-Designation	S185 – S355 GP240R L210 – L360	P235 – P355 P235GH – P265GH
Ship steels	Quality A, B, C and D	
ASTM	A285 grade C A442 grade 55 , 60 A516 grade 55 , 60 , 65 ,70	A414 grade C, D, E, F A515 grade 55 , 60 , 65 , 70

Typical Weld Metal Composition (%)

C	Si	Mn	P	S	Fe
<0.10	0.5	1.3	<0.025	<0.025	Rem.

All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
>460	530-660	>24	+20°C	>160
			-20°C	>100
			-40°C	>47

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	3,2x450	4,0x450	5,0x450
Current	(A)	80	115	115	150	190

Redrying: 2h at 300°C, if necessary. Interpass temperature: ~ 250°C.

ind.12



= + ~ 70V

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