



PHILSTEEL 7018-1

Coated Low Hydrogen Electrode

PHILSTEEL 7018-1 is a basic extremely low hydrogen electrode for mild steel welding. The excellent mechanical properties make this electrode particularly suitable for critical applications in industrial segment including Off-shore, Oil and Gas, Nuclear and pressure vessels.

Classifications: EN ISO 2560-A E 42 4 B 32 H5, IS 814 EB5629H3 JX

Mechanical Properties:

Yield Strength: 480 MPa

Tensile Strength: 560 MPa

Elongation: 27%

Impact Value: 60J, -46 deg C

Diffusible Hydrogen: <5ml/100g

Chemical Composition:

Alloy Type: C-Mn

Coating: Basic

C	Si	Mn	P	S
0.08	0.53	1.43	0.009	0.005

Welding Parameters:

Welding Positions: All positions

Recommended Current Range

Diameter (mm)		2.5	3.2	4.0	5.0
Length (mm)		350	350	450/350	450
Current (A)	F, V, H	55-85	90-120	120-170	170-200
	V, OH	50-80	80-110	100-160	140-190

PHILARK ALLOYS

REGD. OFFICE & WORKS: E 37, UPSIDC, MG ROAD, HAPUR, UP



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