



PHILSTEEL 7018

Coated Low Hydrogen Electrode

PHILSTEEL 7018 is a basic coated, hydrogen controlled iron powder electrode designed for welding in all positions. It gives tough, crack resistant weld on mild and low alloy steels. It deposits good radiographic quality welds and is ideal for welding resistant structures where stresses cannot be avoided.

Classifications: SFA/AWS A5, 1:E7018, EN ISO 2560 – A:E 42 3 B 32 H5

Mechanical Properties:

Yield Strength: 470 MPa

Tensile Strength: 550 MPa

Elongation: 28%

Impact Value: 100J, -30 deg C

80J, -40 deg C

Diffusible Hydrogen: <5ml/100g

Chemical Composition:

Alloy Type: C-Mn

Coating: Basic

C	Si	Mn	P	S
0.08	0.56	1.02	0.013	0.010

Welding Parameters:

Welding Positions: Flat, Fillet, Vertical Up, Horizontal, Overhead

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	70-100	100-140	150-200	190-240
	V, OH	60-90	80-120	120-160	140-180

PHILARK ALLOYS

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



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