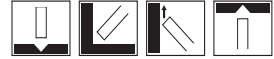


Manual Metal Arc Electrodes

Low Hydrogen MMA Electrodes

Fortrex 7018



AWS A/SFA 5.1-91 E7018
EN 499 E 42 3 B 32 H5
EN ISO 2560-A E 42 3 B 32 H5

Description and applications

Fortrex 7018 is a basic-coated, hydrogen controlled electrode designed for all-positional (except vertical-down) welding of carbon and medium tensile steels, and of mild steels under conditions of high restraint.

Approvals

ABS : 3H, 3Y DNV : 3YH10 MOD : MS>25mm,
BV : 3, 3YH LR : 3, 3Y, H15 (Navy) B & BX >12mm
CE EN 13479

All-weld metal properties

Chemical Composition

	All weld metal %	
	Min	Max
C		0.10
Si	0.30	0.70
Mn	0.85	1.35
S		0.03
P		0.03
Cr		0.19
Ni		0.29
Mo		0.19
V		0.049
Nb		0.049
Cu		0.29

Mechanical

YS
UTS
Elongation

As-welded

420 min N/mm²
510-640 N/mm²
22 min %
Charpy V impact values at -30°C 54 min ave J

Comments

Mn+Ni+Cr+Mo+V < 1.75%

Current range AC (min OCV 60) or DC +/-

Size (mm)	2.5	3.2	4.0	5.0	6.0
Current (amps)	75-90	90-130	120-180	160-220	250-300