

# SUNTHERM 7018 G

Low Hydrogen Electrode



## CLASSIFICATION

IS 1395-82 : E49B-G126  
AWS/A 5.5 : E 7018 G

## CHARACTERISTICS

An iron powder low hydrogen electrode yielding 0.5% Ni in the weld metal. Electrodes is specially manufactured for excellent notch toughness at sub zero temperature even when welded in vertical up hill progression. Electrode gives radiographic weld and metal recovery is over 110%.

## APPLICATIONS

Low alloy steels such as Si-Mn steels, Steel containing up to 1.0% Ni, Heavy sections and restrained joints subject to dynamic loading.

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus	Nickel
0.075	1.48	0.43	0.019	0.018	0.58

## MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	Impact (CVN) at 0° C
494.0 N/mm <sup>2</sup>	596.0 N/mm <sup>2</sup>	25.40%	62%	52 Joules avg

## PACKING DATA:

Size (mm)	Length (mm)	Current (Amp) AC 70 V or DC (+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard Box
2.50	350	70-100	5 Kg	20 Kg
3.15	450	100-130	5 Kg	20 Kg
4.00	450	140-180	5 Kg	20 Kg
5.00	450	180-240	5 Kg	20 Kg
6.30	450	240-300	5 Kg	20 Kg

## RECOMMENDATIONS:

Re-dry the electrodes at 350°C for one hour or at 250°C for two hours. Use short arc to the extent possible.