

# S-7018.1H

Type : Basic



## Conformances

AWS A5.1/ ASME SFA5.1 E7018-1 H4R  
 JIS Z3211 E4918 H5  
 EN ISO 2560-A-E42 4 B 3 2 H5  
 ABS 4Y H5  
 LR 4Y H5

BV 4Y HHH  
 DNV-GL 4YH5  
 CWB CSA W48 E4918-1 H4  
 CE

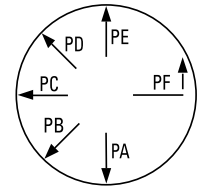
## Applications

- Heavy steel fabrication
- Low temperature strength steel
- Offshore structure

## Features

- Extra low hydrogen electrode
- Good impact value at -45°C
- Vacuum sealed package available (HDM ≤ 4ml/100g)

## Welding Position



## Current

AC or DC +

## Redrying Conditions

350~400°C (662~752°F) X  
 0.5~1hr

## Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)	✓		✓		✓		✓	
3.2 (1/8)	350 (14)	✓		✓		✓		✓	
4.0 (5/32)	400 (16)	✓		✓		✓		✓	
5.0 (3/16)	400 (16)	✓		✓		✓		✓	

SWAW

SAW

GMWAW

GTAW

FCAW

Non-FERROUS

APPENDIX

**Typical Chemical Composition of All-Weld Metal (%)**

C	Si	Mn	P	S
0.06	0.25	1.35	0.014	0.005

**Typical Mechanical Properties of All-Weld Metal**

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
493 (71,500)	566 (82,100)	30.8	-45 (-49)	152 (112)

**Typical Welding Parameters / Amp.(A)**

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	400 (16)	450 (18)	450 (18)
F	60-90	90-140	130-190	180-240
V-up, OH	50-80	80-120	120-170	150-200