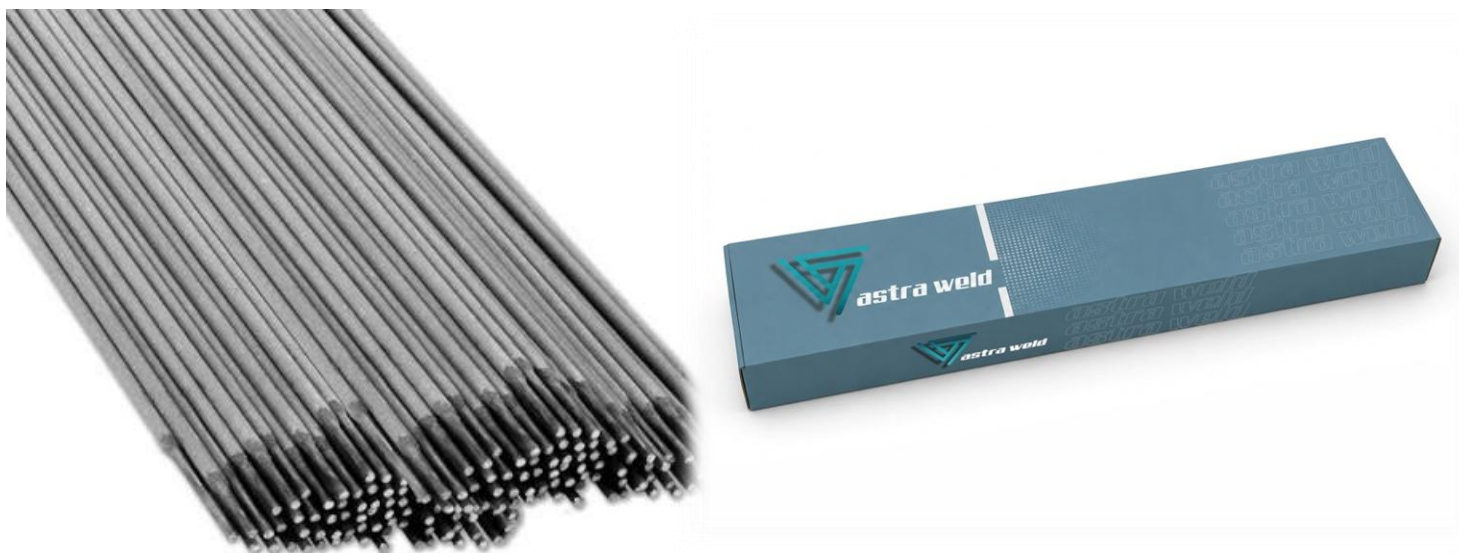




ASTRA E7018

Standards	Classifications
TS EN ISO 2560-A	E 42 4 B 42 H5
AWS/ASME SFA-5.1	E 7018

Features and Applications :

E7018 is a low-hydrogen-potassium-iron-powder coated carbon steel electrode. The iron powder in the coating increases the deposited rate. It has very good usability that enables it to have a stable arc, low-spatter, removal of slag is easy and performs all-position welding. The deposited metal has good mechanical properties that offer very good low temperature toughness.

It is applied in welding structures made of carbon steel and low-alloy steel such as 16Mn.

Dimensions and Weights :

2,50 mm - 3,25 mm - 4,00 mm - 5,00 mm / 1kg - 5kg - 6.5 kg

Chemical Composition :

Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
Standard	≤0.15	≤1.60	≤0.90	≤0.035	≤0.035	≤0.30	≤0.20	≤0.30	≤0.08
Item	0.077	1.07	0.54	0.005	0.014	0.011	0.028	0.007	0.016

Mechanical Properties of Deposited Metal :

Test Item	Rm (N/mm ²)	Rel (N/mm ²)	A(%)	KV2(J) 0℃
Standard	≥490	≥400	≥20	≥27
Item	550	455	32	156

Reference Current (DC) :

Diameter	2.5	3.2	4.0	5.0
Amperage	60~100	80~140	110~210	160~230

Welding Positions :

