

CLASSIFICATION

EN ISO 2560-A : E 42 3 B 42 H5
AWS A5.1 : E7018

GENERAL DESCRIPTION

L-7018 H5 is a basic coated electrode. It is used particularly to weld rigidly restrained mass structures where high welding stresses are unavoidable. Weld metal has a high resistance to cracking. The slag is easy to remove and it gives excellent quality, smooth weld beads. It is also suitable for welding in vertical upwards position at a high welding speed. It has 125% metal recovery.

APPROVALS

CE, GOST, TSE

ABS	BV	DNV	GL	LRS	TL
3H5, 3Y	3YHHH	3YH5	3YH5	3m 3Ym H5	3YH5

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn
0.07	0.50	0.90

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

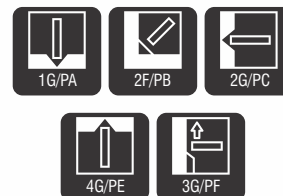
Yield Strength	: 460 N/mm ²
Tensile Strength	: 530 N/mm ²
Elongation (L=5d)	: 28 %
Impact (ISO-V)	: 110 J (-30°C) 80 J (-40°C)

Redrying Temperature : 350-400°C / 3 hrs

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
2.50	350	80 - 110	2420	4.8 / 200	5
3.25	350	110 - 145	3800	5.1 / 135	5
4.00	450	130 - 190	7230	6.5 / 90	6
5.00	450	190 - 245	10700	6.4 / 60	6



APPLICATIONS AND MATERIALS TO BE WELDED

L-7018 H5 is suitable for steel constructions and machines operating under dynamic forces. Ship building, boiler and pressure vessel manufacturing and pipe connections are among its application areas. It is recommended for the welding of high carbon, high strength low alloyed steels having high (P) and (S) content; high strength ship's plate of A-, D- and E- quality and vessel plates of 17 Mn 4 and 19 Mn 5 type. L-7018 H5 can join steel parts to steel casts and can be used in welding of thick parts. It is suitable for the root pass and welding in difficult positions. It gives excellent weld beads with high impact strength values at subzero temperatures. It is also very suitable for welding of GALVANIZED plates.

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2 C 55, Ck 55	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335 C55
Fine Grained Steels	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P355GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, D, E AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52, GS-62	GE200, GE240, GE260, GE300

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.

Fumes : Consult information on Welding Safety Sheet, available upon request.

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