

### CLASSIFICATION

Accord GB/T 5117 E5018  
AWS A5.1 : E7018

### GENERAL DESCRIPTION

LC-7018 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.

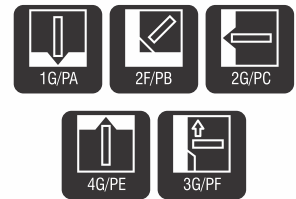
### APPROVALS

ABS	BV	DNV	GL	LR	CCS	NK
3H10, 3Y	3YHH	3YH10	3YH10	3Ym H15	3YH10	KMW 5317

### WELDING PARAMETERS / WELDING POSITIONS

Current Type and Polarity : (AC, DC)

Diameter [ mm ]	Length [ mm ]	Current [ A ]
2.00	300	50 - 80
2.50	350	60 - 100
3.25	350	100 - 150
4.00	400	170 - 210
5.00	400	210 - 250



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

C	Si	Mn	Mo	Ni
0.07	0.50	0.90	0.05	0.3

### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 400 - 480 N/mm <sup>2</sup>
Tensile Strength	: 530 N/mm <sup>2</sup>
Elongation (L=5d)	: 28 %
Impact (ISO-V)	: 110 J ( - 30°C) 80 J ( - 40°C)

Redrying Temperature : 350-400°C / 1-2 hrs

### APPLICATIONS AND MATERIALS TO BE WELDED

LC-7018 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. LC-7018 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
<b>General Structural Steels</b>	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
<b>Fine Grained Steels</b>	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1
<b>Pipe Materials</b>	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P355GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, D, E AH32 - EH36	- -
<b>Cast Steels</b>	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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