

ArcTrode® | E7018-1

Mild Steel **STICK ELECTRODE/SMAW**

Standards

EN/ISO-Standard - 2560-A

AWS-Standard - A5.1

EN/ISO-Classification - E 42 5 B 32 H5

AWS-Classification - E7018-1

Features and Applications

- General purpose basic coated low hydrogen electrode suitable to weld C-Mn and low-alloy Steel.
- Suitable for shipbuilding, construction work, boilers, tanks and vehicle construction
- Weld metal has good toughness properties down to -50°C
- Exceptional overall operability resulting in high quality weld deposits.
- Stable arc, low spatter, smooth weld bead appearance and self-releasing slag.
- Factory vacuum-sealed aluminium packaging.
- Re-drying 250-350 °C for 2 hours.
- Test Certificates can be found online @wilkinsonstar247.com



Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PF, PE

Polarity

AC; DC (+)(-)

Welding Parameters

Ø mm	2.50	3.20	4.00
Current (A)	65-110	100-145	135-200

Mechanical Properties (Typical)

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
≥510	420	≥22	≥47	-50°C

Mechanical properties are approximate and may vary based on the heat, welding parameters and other factors.

Analysis of all-weld metal % (Typical)

C %	Si %	Mn %	P %	S %
0.07	0.35	1.2	0.03	0.03

Packaging Data

Part No.	Diameter x Length Ø (mm)	Packet Weight (Kg)	Electrode Pieces Per/Packet	Carton Weight (Kg)
8011100419	2.50 x 350	5	~245	15
8011100422	3.20 x 450	5	~115	15
8011100425	4.00 x 450	5	~76	15

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

