

Classifications

EN ISO 2560-A:2006	: E 42 5 1Ni B 32 H5	JIS Z 3211	: E4918-G H5
EN ISO 2560-B:2006	: E 49 18-G A H5		
AWS A5.5-06	: E7018-G H4R		

Description

- Covering is low hydrogen, iron powder type for welding of 1%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Fast, efficient metal transfer in all positions and very low hydrogen contents. (HD ≤4ml/100g)
- Excellent notch toughness of the deposited weld metal at low temperature.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.04	0.24	0.91	0.016	0.016	1.01	0.05	0.02	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-50°C	
AWS A5.5	min. 390	min. 490	min. 22			
EN ISO 2560-A	min. 420	500~640	min. 20		≥ 47	
Example	520	600	34	100	70	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp. (A)	F V · OH	60~90 50~80	90~140 80~120	150~190 120~160	180~230 -