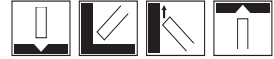


Manual Metal Arc Electrodes

Low Hydrogen MMA Electrodes

Ferex 7018LT



AWS A/SFA 5.1-91 E7018
EN 499 E 42 4 B 32 H5
EN ISO 2560-A E 42 4 B 32 H5

Description and applications

Ferex 7018LT is a basic-coated hydrogen controlled electrode for welding mild and medium tensile steels, particularly under conditions of high restraint.

Approvals

ABS : 3H10, 3Y	DNV : 3 YH10	MOD : MS >25mm,
BV : 3H	LR : 3, 3Y H15	(Navy) B & BX >12mm
Vd TÜV : 03862	GL : 3YH10	UXW frames to QT28 hulls.
CE EN 13479		

All-weld metal properties

Chemical Composition

All weld metal %

	Min	Max
C		0.10
Si	0.25	0.75
Mn	0.90	1.60
S		0.03
P		0.03
Cr		0.1
Ni		0.1
Mo		0.1
V		0.04

Comments

Mn+Ni+Cr+Mo+V < 1.75%

Mechanical Properties of Weld Metal

All weld metal

AWS

As welded

Properties	Min	Max
ReL (MPa)	430	
Rm (MPa)	540	650
A4-A5 (%)	22	
Charpy V at -20°C (J)	54	
Charpy V at -30°C (J)	47	
Charpy V at -40°C (J)	35	

Current range AC (min OCV 60) or DC +/- (DC-VE preferred)

Size (mm)	2.5	3.2	4.0	5.0
Current (amps)	70-110	110-150	150-200	190-260