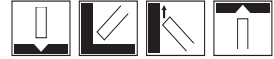


# Manual Metal Arc Electrodes

## Low Hydrogen MMA Electrodes

### Fortrex 7018



AWS A/SFA 5.1-91 E7018  
EN 499 E 42 3 B 32 H5  
EN ISO 2560-A E 42 3 B 32 H5

#### Description and applications

Fortrex 7018 is a basic-coated, hydrogen controlled electrode designed for all-positional (except vertical-down) welding of carbon and medium tensile steels, and of mild steels under conditions of high restraint.

#### Approvals

ABS : 3H, 3Y                      DNV : 3YH10                      MOD : MS>25mm,  
BV : 3, 3YH                      LR : 3, 3Y, H15                      (Navy) B & BX >12mm  
CE EN 13479

#### All-weld metal properties

Chemical Composition

	All weld metal %	
	Min	Max
C		0.10
Si	0.30	0.70
Mn	0.85	1.35
S		0.03
P		0.03
Cr		0.19
Ni		0.29
Mo		0.19
V		0.049
Nb		0.049
Cu		0.29

#### Mechanical

YS  
UTS  
Elongation

#### As-welded

420 min                      N/mm<sup>2</sup>  
510-640                      N/mm<sup>2</sup>  
22 min                      %  
Charpy V impact values at -30°C                      54 min ave                      J

#### Comments

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

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

Size (mm)	2.5	3.2	4.0	5.0	6.0
Current (amps)	75-90	90-130	120-180	160-220	250-300