SC 7018 H4R

Mild steel electrode

Classification

AWS A5.1: E 7018 H4R	EN 499: E 42 4 B 42 H5	EN ISO 2560: E 42 4 B 42 H5

Description and applications

Basic heavy coated, iron powder, low hydrogen LMA type electrode for producing tough and crack-free welded joints even on steels having a carbon content up to 0.40%. Good operating characteristics when positional welding. Weld metal has good toughness properties down to -40°C. Used in structural engineering, boilers, tanks, bridges, ship building, vehicle constructions.

- H4R grade, outstanding low moisture pick up.
- Ultra smooth finely rippled weld beads.
- Less than 4.0 ml /100g diffusible hydrogen.
- Excellent impact notch toughness at -40ºC.
- Superior reliability for the critical welding of C-Mn microlloyed & low alloy structural steels.
- Recommended for critical security welding applications.
- Radiographic out of position welds including pipe welding.
- Suitable for marine and off shore applications.

Base materials

S(P)235-S(P)420; GP240-GP280; L245-L360

All weld metal mechanical properties (typical)

Heat Treatment	Tensile strength Rm (N/mm2)	Yield strength Rm (N/mm2)	Elongation A5 (%)	Impact energy ISO- V (J) -40°C
As welded	550-640	>450	28	80

Typical weld metal chemical composition (%)

C	Si	Mn	P	S
0.07	0.38	1.30	0.020	0.020

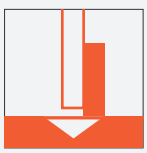
Amperes (A)

2.50	3.20	4.00	5.00
60-80	110-135	140-180	180-230

Storage

Keep dry and avoid condensation.

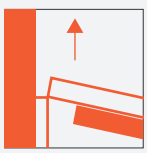
Welding positions



1G/PA

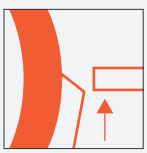
2F/PB

2G/PC



3G/PF

4G/PE



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