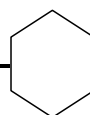




MICRO™

MICRO 7018

C-Mn STEEL (Low Hydrogen)



CLASSIFICATION : EN ISO 2560-A

AWS A/SFA 5.1

E 38 2 B 32

E 7018

KEY FEATURES :

- Basic coated electrode
- Low hydrogen iron powder type
- Tough and ductile weld
- Radiographic weld deposit
- Deposition efficiency upto 110-115%
- All position capability
- Pipe welding in 5G and 6G positions

TYPICAL APPLICATIONS :

- Structural welding
- Storage tanks
- Boilers, Pressure vessels
- Bridges, Pipes
- Joining steel ASTM SA 414/414M Gr.C/D/E, SA 516/516M Gr.55/60

CHEMICAL COMPOSITION %

	C	Mn	Si	S	P
Typical	0.07	1.0	0.5	0.02	0.02
Specification	0.10 max	1.60 max	0.75 max	0.03 max.	0.03 max.

ALL WELD MECHANICAL PROPERTIES

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	525	440	26	55
Specification		490 min	400 min	22 min	27 min

PARAMETERS - PACKING DATA :

Size(mm)	Amperage,A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
5.00 X 450MM	180-240	5	4	20
4.00 X 450MM	120-190	5	4	20
3.15 X 350MM	90-135	5	4	20
3.15x450MM	90-135	5	4	20

EQUIVALENT: GMAW wire: Automig-70S-6 FCAW wire: Automig-FC-71T-1, Automig-FC-121