

**ROYAL 7018 G (E 7018 G)**

AWS : SFA 5.5, E 7018 G

**Applications**

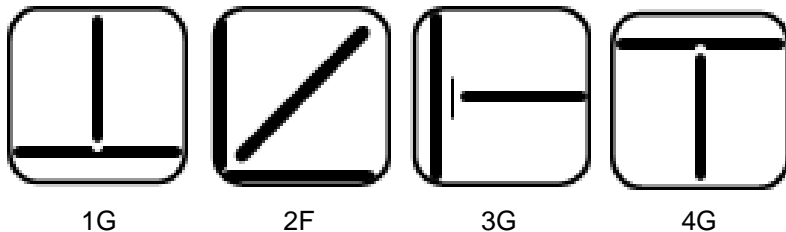
Welding of high strength steel, heavy duty structural fabrication, fine grained, Q & T steel, pressure vessels, tanks, Penstocks.

**Characteristics on Usage**

A basic coated low hydrogen iron powder type electrode. it is used for welding heavy section of fine grained, high strength steel. It's running very smooth and easy slag removable, yielding a weld deposit containing 1.50%Mn and 0.7%Ni. it gives radiographic quality and low temperature service down to minus 60°C.

**Notes On Usage**

- 1) Dry the electrodes at 350 -400°C for 60 min before use.
- 2) Keep the arc as short as possible .
- 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose because ar striking o the base metal is in danger of initing cracking.

**Welding Positions****Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %
0.090 Max	1.60 Max	0.30 Max	0.030 Max	0.030 Max	1.50 Max

**Mechanical Properties Of Weld Metal**

U.T.S.	Y.S.	ELONGATION	IMPACT (CVN)	Hydrogen (Mercury method)
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L = 4d ) %	AT – 50 ° C ( J )	in 100gram weld metal
520 Mn	450 Min	22 % Min	40 Joules Min	5 ml (Max)

**Approvals**

E.I.L

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	150	600	AC / DC (+)	70 – 90
3.15 x 450	100	400		90 – 130
4.00 x 450	70	280		140 – 180
5.00 x 450	45	180		180 – 230