

## Stick electrode

**Features:** ▪ Suitable for low temperature service steel

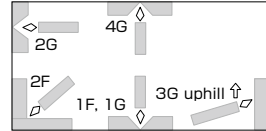
**Classification:** AWS A5.1 E7018-1

**Redrying Conditions:** 350~400°Cx1h

**Identification color:** 1st Brown, 2nd White

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	23	170W, 105H, 380L
3.2	350	5	20	35	170W, 105H, 380L
4.0	400	5	20	61	170W, 105H, 430L
4.0	450	5	20	69	170W, 100H, 480L
5.0	450	5	20	106	170W, 110H, 480L

## Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty <sup>a</sup>
<b>C</b>	0.08	0.15
<b>Si</b>	0.37	0.75
<b>Mn</b>	1.53	1.60
<b>P</b>	0.012	0.035
<b>S</b>	0.003	0.035
<b>Ni</b>	0.01	0.30
<b>Cr</b>	0.03	0.20
<b>Mo</b>	0.01	0.30
<b>V</b>	<0.01	0.08
<b>Ti</b>	0.025	-
<b>B</b>	0.0045	-
<b>Others<sup>b</sup></b>	1.58	1.75

Note: <sup>a</sup> Single values are maximum.

<sup>b</sup> Combined Limit for Mn+Ni+Cr+Mo+V

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	70~100	65~95
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	-

## All-weld mechanical properties

	Typical (DCEP)	Guaranty
<b>0.2%YS (MPa)</b>	490	400min.
<b>TS (MPa)</b>	580	483min.
<b>EI on 4d (%)</b>	31	22min.
<b>IV -46°C (J)</b>	135	27min.

## Approvals

<b>ABS</b>	4Y400, H10
<b>LR</b>	4Y40m H10