

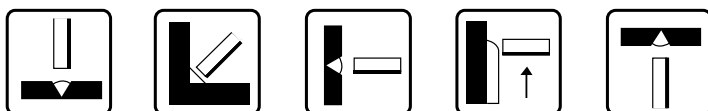


MILD STEEL ELECTRODES

E7018

CWB to CSA W48-14
Classification: E4918
AWS/ASME A5.1 - 04 E7018

Suitable welding positions



Typical applications

Covering is low hydrogen, iron powder; common of welding applications include 71 ksi (490 MPa) class high tensile strength steels found in structural steels for buildings, bridge construction, storage tank fabrication, ship building, industrial and mining machinery fabrication.

Characteristics on usage

- Very good striking and re-striking properties
- Excellent usability with direct current applications
- Excellent mechanic properties and radiographic soundness
- Good bead appearance and slag removal
- Re-dry the electrode at 300-400°C for 60-120 minutes prior to use

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.07	0.61	0.87	0.015	0.011	0.03	0.02	0.01

Minimum typical mechanical properties of all-weld-metal

Yield Strength		Tensile Strength		Elongation	Impact Value
480 MPa	69 ksi	570 MPa	82 ksi	30%	70J (-30°C)

Dimensions and recommended currents

Vanguard Code	Diameter		Length		Amperage	
	inches	mm	inches	mm	F & HF	VU & OH
6188 2400	3/32	2.6	11.8	300	60 - 100	50 - 80
6188 3200	1/8	3.2	13.8	350	90 - 130	80 - 120
6188 4000	5/32	4.0	13.8	350	130 - 180	110 - 170
6188 5000	3/16	5.0	13.8	350	200 - 250	160 - 210
6188 6400	1/4	6.0	17.7	450	250 - 310	---

Standard packaging

Sleeve		Master Carton		Pallet	
4.5 Kgs	10 Lbs	22.5 Kgs	50 Lbs	1,260 Kgs	2,780 Lbs