LEADER IN INDUSTRIAL TOOLS & EQUIPMENT

Technical sheet



Basic Iron Powder Type Electrode - E7018

Marque: TJB

Ref Product: wire:THJ506Fe

Ref Mcmining: SOUDE70183

Description

Basic Iron Powder Type Electrode - E7018

Application :

Suitablefor the welding ofcarbon steel and alloy steel structure such as Gr.50 and so on.

Charasteristique

Basic potassium-iron powder tupe electrode with low hydrogen

AC & DC can be used and can be weld for all-position

Excellent welding performance as good arc stifness,little spatter,easy slag removel…and higher deposition efficiency

Welding position

PA, PB, PC, PE, PF

Certification

AWS A5.1 E7018
ISO 2560-B-E4918 A
GBT 5117 E5018

Chemical composition of all weld metal

Items	C	Mn	Si	S	P	Ni	Cr	Mo	V
Requirement	?0.10	0.85-1.40	?0.65	?0.030	?0.035	?0.30	?0.20	?0.30	?0.08
Typical results	0.06	1.00	0.30	0.015	0.020	0.030	0.035	0.005	0.004

MechanicalPropeties of ALL Weld Metal

Items	RmMPa	Rel/Rpo2/MPa	A/%	KV2(-30°C)J
Requirement	490-660	?400	?22	?80
Typical results	590	480	28	160

X-ray Radiograhic Inspection

LEVEL I

Typical Operating Procedure (AC or DC)

Diam (mm)	Lenght (mm)	Current (A)	Designation	Ref	Ref Mc Mining
2.5	300	60-100	ELECTRODE E7018 2.5X300MM (2.5KG/BOX) THJ506Fe	THJ5062.5X300	**SOUDE70182.5X300**
3.2	350	100-150	ELECTRODE E7018 3.2X350MM (5KG/BOX) THJ506Fe	THJ5063.2X350	**SOUDE70183.2X350**
4.0	350	170-201	ELECTRODE E7018 4.0X400MM (5KG/BOX) THJ506Fe	THJ5064.0X400	**SOUDE70184.0X400**
3.2	350		ELECTRODE E7018 3.2X350MM THJ506Fe -1H4R	THJ5061H4R3.2X400	**SOUDE70181H4R3.2X350**