

Product Data Sheet

Fortrex 7018™



Meeting the fabrication industry's highest welding expectations

Description and Applications

Fortrex 7018 is a basic-coated, hydrogen/controlled electrode designed for all-positional (except vertical-down) welding of carbon, low-alloy and medium tensile steels, and of mild steels under conditions of high restraint.

Classification

AWS A/SFA 5.1-91 E7018;
EN 499 E 42 3 B 32 H5;
EN ISO 2560-A E 42 3 B 32 H5

Type of covering

Basic-coated
Hydrogen controlled

Type of current

AC, DCEP or DCEN

Welding Positions



Comments:

Mn+Ni+Cr+Mo+V < 1.75%

Current range:

Dia x length (mm)	2.5 x 305	3.2 x 400	4.0 x 400	5.0 x 400
Current (amps)	75-90	90-130	120-180	160-220

Chemical composition of deposited metal (%)

	C	Si	Mn	S	P	Cr	Ni	Mo	V	Nb	Cu
Min		0.30	0.85								
Max	0.10	0.70	1.35	0.30	0.30	0.19	0.29	0.19	0.049	0.049	0.29

Mechanical Properties of deposited metal (AW)

Tensile strength (N/mm ²)	Yield strength (N/mm ²) minimum	Elongation (%)	Charpy V impact values at -20°C
510-640	410	22	162 (Joules)

Storage and redrying:

Keep in a dry place and re-dry immediately before use at 350 °C for 90-120 minutes in a vented oven and thereafter use from a hot box set at 100-120 °C

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