

AWS A5.1-04:
AWS A5.1M-04

E7018
E4918

BÖHLER FOX 7018

SMAW basic electrode, carbon steel

DESCRIPTION:

Basic electrode with good welding characteristics. Metallic yield of 110%. Good weldability in all positions, except descending vertical. Ideal for welding steel with low contents of impurity and high contents of carbon. Applied in metallic structures in general, welding in tanks, construction of machines and equipment, buttering upon reconstruction of steel with high content of carbon.

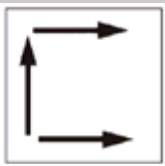
TYPICAL CHEMICAL COMPOSITION OF THE DEPOSITED METAL:

% Weight	%C	%Si	%Mn
	0.07	0.4	0.8

TYPICAL MECHANICAL PROPERTIES OF THE DEPOSITED METAL:

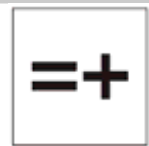
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Flow Limit (LE) N/mm ² :	400
Resistance Limit (LR) N/mm ² :	490
Stretching (S) [L ₀ = 5d ₀] %:	22
Charpy Impact V (J)	-30°C 27

OPERATIONAL DATA:



Drying, if necessary:
Time: 2 - 10 h
Temperature: 300-350°C

Ømm	L (mm)	Current (A)
2.50	350	80 - 110
3.25	350	110 - 150
4.00	450	130 - 180
5.00	450	180 - 230
6.00	450	240 - 290



BASE METALS:

Steel with up to 490 N/mm² of flow limit (70 ksi).

S235JR-E335, S235J2G3 –S355J2G3; C22, P235T1-P355T1, P235T2, P355T2, L210 –L360NB L290MB –L320MB, P235G1TH, P255G1TH, P235GH, P265GH, P295GH, S235JRS1 –S235J4S, S355G1S –S355G3S, S255N –S355N, P255NH-P355NH, S255NL –S355NL, GE200-GE260, GE300.

ASTM A 27 a. A36 Gr.all; A214; A242 Gr. 1-5; A266 Gr. 1,2,4; A283 Gr. A,B,C,D; A285 Gr. A,B,C; A299 Gr. A,B; A328; A366; A515 Gr. 60,65,70; A516 Gr.55; A570 Gr.30,33,36,40,45; A572 Gr.42,50; A606 Gr. all; A607 Gr.45; A656 Gr.50,60; A668 Gr.A,B; A907 Gr.30,33,36,40; A841; A851 Gr.1,2; A935 Gr.45; A936 Gr.50; API 5 L Gr.B, X42 –X56.

WARNING: The information presented herein is not a guarantee or certification for which we can be held legally responsible; this may be altered without previous notice.

Abr/2008 Rev. 0

WELDING - 0800-119002