

Product Data Sheet

MMA Electrodes C-Mn and low-alloy steels

SUPER OPTIMAL 7018

- Superior weldability, ultra smooth finely rippled weld beads
- Less than 4.0 ml diffusible hydrogen level.
- Superior reliability for the critical welding of C-Mn microalloyed & low alloy structural steels.
- Radiographic out of position welds including pipe welding.

Classification **AWS A5.1** : E7018 **DIN EN ISO 2560-A**: E 42 4 B 32 H5 **IS 814**: EB 5426H3JX

Description and applications

Hydrogen controlled Iron powder, basic heavy coated MMA electrode for crack resistant, reliable welds and excellent toughness values at low temperatures on unalloyed and low alloyed steels, high tensile fine grained steels upto - 40°C. Superior weldability, stable arc, self releasing slag, very low spatters, smooth bead appearance, good striking and re-striking. Low moisture absorption properties (LMA-Type). Used in structural engineering, ship buildings, bridges, boilers, tanks etc.

Base materials

S(P)235-S(P)420; GP240-GP280; L245-L360

Typical Weld Metal Chemical Composition(%)

C	Si	Mn	P	S
0.07	0.40	1.20	0.020	0.020

All weld metal Mechanical Properties (Typical)

Heat Treatment	Tensile Strength R_m (N/mm ²)	Yield Strength R_p (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V J-30°C)
As welded	550-620	450	28	100







Amperes (A)

2.50mm	3.15mm	3.20mm	4.00mm	5.00mm
50-90	100-140	100-140	130-180	180-230

Welding instruction

Keep dry and avoid condensation,
Re-dry electrodes at 350°-400°C or 1-2 hrs, if necessary.

Welding Positions

						=+	~70V
1G/PA	2F/PB	2G/PC	3G/PF	4G/PE	PF2		

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