



MILD STEEL ELECTRODES

E7018-1

CWB to CSA W48-14
 Classification: E4918-1-H8
 AWS/ASME A5.1 - 04 E7018-1

Suitable welding positions



Typical applications

Covering is low hydrogen, iron powder; common of welding applications include structural steels for buildings, bridge construction, storage tanks fabrication, ship building, and industrial and mining machinery fabrication., fabrication and repair of liquefied petroleum gas storage tanks

Characteristics on usage

- Excellent impact value at -46 °C (-51 °F)
- Very good striking and re-striking properties
- Excellent usability with direct current applications
- Excellent mechanical 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	0.58	1.38	0.013	0.012	0.03	0.15	0.01

Minimum typical mechanical properties of all-weld-metal

Yield Strength		Tensile Strength		Elongation	Impact Value
510 MPa	74 ksi	590 MPa	85 ksi	32%	75J (-45 °C)

Dimensions and recommended currents

Vanguard Code	Diameter		Length		Amperage	
	inches	mm	inches	mm	F & HF	VU&OH
6189 2400	3/32	2.6	11.8	300	70 - 100	60 - 90
6189 3200	1/8	3.2	13.8	350	90 - 130	85 - 120
6189 4000	5/32	4.0	13.8	350	150 - 190	110 - 160
6189 5000	3/16	5.0	13.8	350	160 - 220	130 - 180
—	1/4	6.0	17.7	450	180 - 230	—

Standard packaging

Sleeve		Master Carton		Pallet	
4.5 Kgs	10 Lbs	22.5 Kgs	50 Lbs	1,125 Kgs	2,500 Lbs