

LB-7018-1

TRUSTARC™

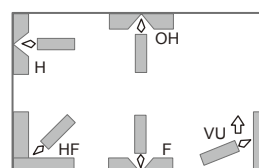
Iron powder low hydrogen type covered electrode

Classification: ASME / AWS A5.1 E7018-1
EN ISO 2560-A-E 42 4 B

Features: •Suitable for butt and fillet welding of structures for low temperature service steel

Redrying Conditions: 350~400°Cx1 h

Welding Positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S	Ti	B
Example	0.07	0.40	1.57	0.011	0.003	0.025	0.0035
Guaranty	≤0.15	≤0.75	≤1.60	≤0.035	≤0.035	-	-

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	490	580	31	-46°C: 135	AW
Guaranty	≥400	≥480	≥22	-46°C≥27	AW

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	70~100A	90~130A	130~180A	180~240A
VU, OH	65~95A	80~120A	110~170A	-

Polarity

Example	DC-EP
Guaranty	AC, DC-EP

Approvals

ABS	LR
4Y400,H10	4Y40m H10

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	350	5	20	23
3.2	350	5	20	35
4.0	400	5	20	61
	450	5	20	69
5.0	450	5	20	106