

BASIC ELECTRODE

PAK BRIDGE E 7018



KEY FEATURES

1. DEEP PENETRATION
2. LESS SPATTER
3. FINE APPEARANCE
4. EASILY REMOVEABLE SLAG
5. GOOD MECHANICAL PROPERTIES OF HIGH TENSILE STRENGTH AND TOUGHNESS

SWAW

CLASSIFICATION

AWS : E7018, ISO : E432 R11, DIN : E4322 R (C) 3

GENERAL DESCRIPTION

Pak Bridge E-7018 is a low hydrogen basic coated electrode containing iron powder. Deposited metal is the 520 N/mm² in tensile class and has excellent X-ray soundness. The addition of Iron powder gives excellent side wall wash feature and results in improved arcing characteristics with higher recovery. It can be used in any position with AC or DC.

APPLICATIONS

Pak Bridge E7018 is applied in welding structures made of carbon steel and low alloy steel such as 16Mn, uniform and soft metal transfer, easy to control weld pool and slag, suitable in DC (+), Neat weld profile in fillet joints, High tensile strength and excellent toughness in sub-zero temperatures, suitable for highly restrained joints.

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD META L

C	Mn	Si	S	P
≤0.15	1.60	≤0.90	≤0.035	≤0.035

MECHANICAL PROPERTIES, OF DEPOSITED METAL

Item	Tensile Strength	Yield Strength	Elongation	*CVNAT-20°C
Units	N/mm ²	N/mm ²	%	J
General Result	>550	>455	32	120

ELECTRODE SIZE / CURRENT CONDITION / PACKAGING INFORMATION

Electrode Dia (mm)	2.5mm	3.2mm	4.0mm	5.0mm
Electrode length (mm)	300	350	400	400
Current Range	Min.	60A	80A	110A
	Max.	100A	140A	210A
Packing Information Inner Box Weight (No of PKT) Per Carton	2.5kg(8)	5kg(4)	5kg(4)	5kg(4)
Approx. Electrodes Per Pkt.	140	126	84	51

STORAGE AND RE-BAKING

It is recommended that the Pak Bridge E-7018 electrodes are stored in a dry heated store in a minimum temperature of 18°C, and a maximum relative humidity of 60%. Not more than 6 cartons should be stacked on top of one another to avoid damage to the coatings.

Note:

Before using the electrode must be preheated at the temperature of 350°C for 1 hour. The impurities such as rust, oil stains and moisture must be cleared off the work piece. Short arc is required to perform weldings. Narrow weld path is preferred.

WELDING POSITIONS

