



RASI E 7018 LH

premium

BASIC COATED LOW HYDROGEN
ELECTRODES

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

RASI E - 7018 LH is a basic coated iron powder electrode with hydrogen control electrode. The Arc is stable quite and smooth. Self desposing slag and superb welding performance. Weld metal is of Radiographic quality. High notch ductility at Sub - zero temperature and weld metal recovery is 115% (approx) multi positional electrode.

APPLICATIONS

Welding of mild steel, Pressure Vessel, Ship Plates Boilers, Penstocks and all jobs involving static and dynamic loading. Also welding of heavy sections, free cutting steels etc.

CLASSIFICATIONS

IS. : 814 EB5426H3JX
AWS : A5.1 E-7018

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.10%	Silicon - 0.75%
Manganese - 1.60%	Sulfur - 0.03%
Phosphorus - 0.03%	

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 510 - 650
Yeild Strength (N/mm²) - 360 MIN.
Elongation % - 24% MIN.
CVN Impact at -30°C - 27 J MIN.

WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 100 Amps
Ø 3.15 mm - 100 - 140 Amps
Ø 4.00 mm - 140 - 190 Amps
Ø 5.00 mm - 190 - 240 Amps.
Ø 6.30 mm - 240 - 300 Amps.

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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