

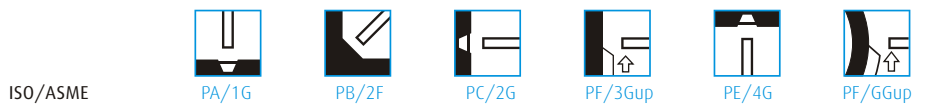


Linde Basic 7018

Classification AWS A5.1: E 7018
ISO 2560-A: E 42 4 B 42 H5

General description Low hydrogen basic electrode designed for producing crack-free and X-ray quality of welded joints. Weld metal exhibits good toughness properties down to -40°C. Good operating characteristics and gap bridging, also in positional welding. Smooth and clean welds blending into base metal without undercut. Suitable for buffer layers on steels having a higher carbon content. Weld metal recovery approx. 115%.

Welding positions



Current type DC +

Approvals TÜV DB BV GL LR
+ + 3YH5 3YH5 3YH5

Chemical composition (w%), typical, all weld metal

C	Mn	Si	HDM
0,05	1,3	0,4	<5ml/100g

Mechanical properties, typical, all weld metal

	Condition	Yield strength	Tensile strength	Elongation	Impact ISO-V(J)	
		(N/mm ²)	(N/mm ²)	(%)	- 46oC	- 40oC
Required:	AWS A5.1	min. 399	min. 482	min. 22	min. 27	
	EN ISO 2560	min. 420	500-640	min. 20	min. 47	
Typical values		480	560	28	100	

Packaging and available sizes

	2.5	3.2	4.0
Diameter (mm)			
Length (mm)	350	350	350
Pieces / unit	205	125	85
Weight of box (kg)	4,6	4,5	4,6

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, E, AH275 to EH36
Cast steel	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240, L290, L360, 415, L445
	API 5LX	X42, X46, X52, X60
	EN 10216-1/ EN10217-1	P235T1, P235T2, P275T1 P275T2, P355N
	Boiler & pressure vessel steel	EN 10028-2
Fine grained steel	EN 10113-2	S275, S355, S420
	EN 10113-3	S275, S355, S420

Welding parameters, optimum fill passes

Welding positions	PA/1G	PB/2F	PC/2G	PF/3G up	PE/4G	PF/5G up
Diameter (mm)						
2,5	95	95	90	90	85	90
3,2	140	130	130	125	120	125
4,0	180	180	180	160		

Application Advice Electrodes after removal from cardboard boxes redry 2-3 h at 250-300°C.