

# E7018

Carbon steel electrode

GB/T E5018

AWS E7018



- E7018 non alloy steel welding electrode, produced by imported technology for alkaline type, + iron powder coated type.
- AC/DC available.
- For all position welding.
- Welding electrode coated with absorbing moisture resistance.
- Weld crack resistance is good, the deposition efficiency of 120%.
- Suitable for carbon steel, low alloy steel, ship welding steel and pressure containers
- Deposited metal chemical composition

C	Mn	Si	S	P	Cr	Ni	Mo	V
≅ 0.15	≅ 1.6	≅ 0.90	≅ 0.035	≅ 0.035	≅ 0.20	≅ 0.3	≅ 0.3	≅ 0.08

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- Deposited metal mechanical properties

	Yield Strength (Mpa)	Tensile Strength (Rm Mpa)	Elongation (%)	Impact KV2 (J) -30 oc
Standard	≧ 490	≧ 400	≧ 20	≧ 27

- X-ray : I grade

- Reference Current:

Diameter	2.5	3.2	4.0	5.0
Welding current (A)	70-110	110-150	150-200	190-260

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- Attention :
- 1--Welding electrode should be baked for 1 hour at 350 °C before welding ,then use after baking.
- 2-- Welding parts should be removed before welding the rust, oil, moisture and other impurities
- 3---Be short arc welding operation, welding is suitable to narrow

• The End

# E6013

Carbon steel electrode

GB/T 5117 E4313

AWS A5.1 E6013



- E6013 ,Non alloy steel welding electrodes with rutile type and reduced titanium type coating.
- AC/DC available.
- For all position welding. Vertical down welding is included.
- The welding electrodes has good performance and high deposition efficiency.
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- The welding seam is smooth and easy to remove slag.  
It is very convenient to strike the arc and re start the arc.  
Therefore, it is also an ideal welding rod. AC welding requires only 50V no-load voltage .

# E6013

Carbon steel electrodes GB/T 5117 E4313

AWS A5.1 E6013



- Deposited metal chemical composition

C	Mn	Si	S	P	Cr	Ni	Mo	V
$\cong 0.20$	$\cong 1.2$	$\cong 1.00$	$\cong 0.035$	$\cong 0.04$	$\cong 0.20$	$\cong 0.3$	$\cong 0.3$	$\cong 0.08$

- Deposited metal mechanical properties

	Yield Strength (Mpa)	Tensile Strength (Rm Mpa)	Alongation (%)	Impact KV2 (J)
Standard	$\cong 306$	400-560	$\cong 22$	$\cong 47$
Usual	380	480	31	95

- Reference Current:

Diameter	2.5	3.2	4.0	5.0
Welding current (A)	60-100	90-150	160-200	200-250

# E6013

Carbon steel electrode GB/T 5117 E4313  
AWS A5.1 E6013



- Used for welding low carbon ship steel structure, can adapt to various forms of welding joints and welding position welding, the welding performance of the thin plate is excellent, especially for short track welding and backing welding.
- Welding electrode need to be baked for 1h at 150 °C about if Moistured.

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**The End**