

Classifications

EN ISO 2560-A:2006	: E 42 4 B 32 H10	JIS Z 3214	: E4918-1
EN ISO 2560-B:2006	: E 49 18-1 A U H10		
AWS A5.1-04	: E7018-1		

Description

- Covering is low hydrogen, iron powder type for welding of nuclear reactor vessels, LPG tankers, LPG storage tanks and similar installations at low temperature.
- Good impact value at -45°C
- Excellent mechanical properties and radiographic soundness.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Sum
0.07	0.58	1.38	0.013	0.012	0.15	0.03	0.01	0.01	1.58

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-45°C	
AWS A5.1	min. 400	min. 490	min. 22		≥ 27	
EN ISO 2560-A	min. 420	500~640	min. 20	≥ 47		
Example	510	590	32	100	75	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	70~100 60~90	90~130 85~120	150~190 110~160	160~220 130~180	180~230 —

Approvals

DNV	LR
5YH10	5Y40mH15

* Others : JIS, CWB, CE