

NST E 7018

AWS: A5.1 E7018

EN ISO 2560-A: E 42 4 B 32 H5



Basic electrode for welding unalloyed and fine grained steels.

General description:

NST E 7018 is a basic, CTOD tested electrode with excellent welding characteristics, recommended for welding structural steels and steel castings with tensile strength up to 610 N/mm², and fine grained steels with increased yield strength.

Weld metal Deposits have a very low hydrogen content (HD < 5 ml/100 g).

Excellent welding properties in difficult positions, except vertical down (PG).

Efficiency of approximately 120%.

This product is also available in a premium vacuum-packed version, with smart 2-in-1 packaging.

VacuumPack SuperDry 2-in-1

Welding positions:



Welding current:

DC+ / AC

Redrying:

400 °C/1 hour

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S					
0,07	0,60	1,00	<0,035	<0,035					

Diffusible hydrogen content (ml/100g):

Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) -40 °C	
≥420	500-640	≥22	≥47	

Guidance - Ampere (DC+ / AC):

Electrode diameter	2,5 mm	3,2 mm	4,0 mm
Ampere / Volt	65-90	110-140	140-180

Packaging information:

2,0 x 300 1,8kg pack ,carton 10,8kg
2,5 x 350 2,0kg pack ,carton 12,0kg
3,2 x 450 2,4kg pack ,carton 14,4kg
4,0 x 450 2,7kg pack, carton 16,2kg
5,0 x 450 2,7kg pack, carton 16,2kg
Vacuum pack: 2,5 x 350 0,7kg(2 x 0,35kg) pack, carton 8,4kg
Vacuum pack: 3,2 x 450 1,1kg(2 x 0,55kg) pack, carton 13,2kg
Vacuum pack: 4,0 x 450 1,4kg(2 x 0,7kg) pack, carton 16,8kg

Approvals:

DNVGL, TÜV, CE

Reference / date:

NST E 7018,
English, 24.08.2018.

Perfect Welding

www.nst.no