

NOUVE[®] 7018

Designation

AWS A5.1 E7018
UNS No. W07018

Welding Positions



Features

- Excellent arc characteristics
- Low moisture re-absorption
- Low spatter level
- Low smoke level
- Quick and easy slag removal
- Radiography quality

Applications

Typical application include heavy structures subjected to dynamic loading and impact, highly restraint joints, boilers and pressure vessels, atomic reactor shells, bridges, railway wagons and coaches, earth moving equipment etc

Type of Current

Direct Current Electrode Positive (DCEP)

Recommended Welding Techniques

- GENERAL : Electrode positive, work negative (DCEP)
 ARC LENGTH : Short arc
 STORAGE : Re-dry electrodes to 300°C for 2 hours before use

Weld Metal Chemistry

	Carbon	Manganese	Silicon	Phosphorous	Sulphur	Nickel	Chromium	Molybdenum	Vanadium
Spec	0.15	1.6	0.75	0.035	0.035	0.3	0.20	0.30	0.08
Typical	0.1	1.23	0.64	0.026	0.022	0.22	0.14	0.22	0.06

Mechanical Properties (as welded)

MECHANICAL TESTS	AWS SPEC		TYPICAL	
Tensile Strength	490 MPa Min		620 MPa	
Yield Strength	400 MPa Min		491 MPa	
Impact Energy (min)	Single Value	20J at -45°C	Single Value	24J at -45°C
	Average Value	27J at -45°C	Average Value	33J at -45°C