

NOUVE[®] 7018-A1

Designation

AWS A5.5 E7018-A1
UNS No. W17018

Welding Positions



Features

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

Applications

Low Hydrogen Basic coated electrode with Mo for creep resisting steel used temperature upto 500°C. Good Resistance to Hydrogen Attack.

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.
 PRE HEAT : 95°C to 110°C for 1 hour

Weld Metal Chemistry

	Carbon	Manganese	Silicon	Phosphorous	Sulphur	Nickel	Chromium	Molybdenum
Spec	0.12	0.90	0.80	0.03	0.03	-	-	0.40-0.65
Typical	0.07	0.84	0.75	0.024	0.024	-	-	0.50

Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Yield Strength	Elongation %	Impact Energy	PWHT
AWS SPEC	490	390	22	NA at NA	620±15
TYPICAL	535	24	24	NA	605