

Fortrex 7018



A basic coated hydrogen controlled electrode designed for all positional welding (except vertical down) of carbon and medium tensile steels and mild steels under conditions of high restraint. The electrode is intended for general fabrication work where hydrogen control is required - this electrode guarantees values below H4.

An iron powder addition is included in the coating, this gives a weld metal recovery of approximately 120%. Striking and re-striking qualities are good and slag is easily removed from the weld.

Classifications:	SFA/AWS A5.1:E7018 H4R, EN ISO 2560-A:E 42 4 B 42 H5
Approvals:	ABS 3Y H5, BV 3Y H5, CE EN 13479, DNV-GL 3Y H5, LR 3Y, LR 3Y H5

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+-, AC
Diffusible Hydrogen:	< 4.0 ml/100g
Alloy Type:	Carbon Manganese.
Coating Type:	Basic covering

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	70-110 A	24 V	0.67 kg	65	57 sec	0.96 kg/h
3.2 x 450 mm	90-140 A	23 V	0.73 kg	31	85 sec	1.33 kg/h
4.0 x 450 mm	120-190 A	24 V	0.71 kg	22	92 sec	1.76 kg/h
5.0 x 450 mm	190-260 A	24 V	0.75 kg	13	99 sec	2.61 kg/h