



Nexus E7018-1

Low Hydrogen electrode for MMA welding of Mild Steel

Basic coated Low hydrogen, Electrode for the joining of steels of Mild and medium Carbon Manganese steels. Exceptional operability in all positions with excellent slag removal and spatter levels. E7018-1 VP enables the electrodes to be used direct from the Vacuum Pack without the necessity for baking whilst still achieving <2ml of hydrogen (scale D).

International Standards

ISO 2560 - A - :2005	AWS A5.1-04
E 42 4 B 32 H5	E7018-1

Typical All-Weld Metal Analysis (wt%)

C	Si	Mn	S	P
0.07	0.50	1.20	≤ 0.025	≤ 0.025

Typical All-Weld Metal Mechanical Properties

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact Strength J @ -50°C
420-510	510-590	>22	40-80

Welding Positions

All positions except vertical down

Materials

ASTM A106 Gr A,B,C.

Packaging

Size mm	2.5 x 350	3.2 x 450	4.0 x 450	5.0 x 450
Pieces/Package	80 (75)	55 (52)	40(36)	26 (24)
Pieces/Carton	480 (450)	330 (312)	240 (216)	156 (144)
Kg/Package	1.78 (1.66)	2.45 (2.31)	2.69 (2.43)	2.69 (2.48)
Packs/Carton	6	6	6	6
Kg/Carton	10.68 (9.96)	14.70 (13.86)	16.14 (14.58)	16.14 (14.88)

Details in brackets are for Vacuum packed

Operating Requirements

DC+/- AC (70ocv min)	65-110 A	100-145 A	135-200 A	180-280 A
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Additional Information

CE Certified	Constructional products directive (CPD)
Certification	BS EN 10204:2004 Type 2.2
Material safety data sheet	MSDS 04
Re-dry	With VP it is possible to obtain weld metal H2 content lower than 5ml/100g of deposited weld metal in a atmosphere of 25°C @ rh80% when product remains in open plastic bags, avoiding direct exposure. Re-dry at 1-2 hours @ 260-425°C if necessary and hold @80°C prior to use for <u>non Vac Pack product only</u>
Related Nexus Products	MIG Nexus SG2/SG3 TIG A15/A18