

JACKSUN-7018W

BASIC COATED, LOW ALLOY STEEL ELECTRODE
DESIGNED FOR WELDING OF WEATHERING STEELS.

BASIC ALLOY: FE, MN, SI, CR, NI, CU
AWS/SFA-5.5: E 7018-W1
UNS NO. W20018

KEY FEATURES:

ROWELD 7018W is an all position iron powder low hydrogen type electrode which exhibits high crack resistibility and superior notch toughness of depositing weld metal. Its is suitable for welding comparatively thick plates of weather proof steel.

APPLICATIONS

- Welding of weathering steels like SAILCOR-A & CORTEN A & B steels & equivalent.
- Medium tensile corrosion resistant structure steels and welding of high tensile steels.
- Electrode suitable for typical weathering steels, such as ASTM A 242 and A 588

RE-DRY CONDITION:

- Re-dry the electrode at -350°C for one hour, for best results

CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Cu	Ni	Cr	V
0.12 max	0.40-0.70	0.40-0.70	0.025max	0.030-0.60	0.20-0.40	0.15-0.30	0.080 max

(Single value maximum)

MECHANICAL PROPERTIES:

YS (N/mm2)	UTS (N/mm2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
415 min	490 min.	22 min	- 20°C : 80-100 J

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 90V)	Kg./pkt.	KG/Case
2.50/ 2.40	3/ 32"	80-100	5	20
3.20	1/ 8"	110-140	5	20
4.00	5/ 32"	150-180	5	20
5.00	3/ 16"	210-260	5	20