



## SUNTHERM 7018

### CLASSIFICATION:

A5.1: E 7018  
IS: 814 EB 5426H3JX

### DESCRIPTION:

SUNTHERM 7018 is heavy coated low hydrogen, iron powder type electrodes ideally suited for producing tough and ductile welds of radiographic quality in boilers, pressure vessels & heavy structures subjected to dynamic loading. The electrode posses metal recovery of about 110%.

### APPROVALS:

BIS,PDIL,IBR

### TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Mechanical Properties	
C	0.10 max	Mn	0.80-1.60	YS	52-62 Kg/mm <sup>2</sup>
Si	0.75 max	S	0.03 max	UTS	45-52 Kg/mm <sup>2</sup>
P	0.03 max			EL (L=5d)	26-35%
				Impact (CVN) at -30°C	49-120 Joules

### TYPICAL APPLICATIONS:

Heavy structures subjected to dynamic loading & impact, highly restrained joints, coaches, wagons, penstocks, boilers, pressure vessels, earthmoving machines etc.

### CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current Range (Amps)	Qty of Electrodes in a Carton	Qty of Electrodes in a Cardboard Box (20 Kg)
2.5	350	60-90	150 x 4	20 Kg
3.15	450	100-130	100 x 4	20 Kg
4.00	450	140-190	65 x 4	20 Kg
4	450	200-260	45 x 4	20 Kg

### PACKING:

Electrodes are packed in Cartons and four of these Cartons are shrink wrapped in a cardboard box.