

Specification

UTP 7018

Basic-coated stick electrode for constructions with high stressed joints, AC-weldable.

AWS : A51: 7018

Application field

UTP 7018 is a double coated stick electrode with a universally suited application field. It is used in industry, trade, as well as in production and repair welds for diverse base materials.

Base materials

Unalloyed construction steels S235JRG2 – S355J2; E295, E335, St35, St 45, St 35.8, St45.8, St50-2
 Boiler steels: P235GH, P265GH, P295GH
 Fine-grained steels: bis S355N
 Shipbuilding steels: A – E, AH - EH
 Cast steels: C 35, GS-38, GS-45

Welding properties

Due to a special coating formula **UTP 7018** shows a smooth and finely rippled weld seam, a stable arc, easy slag removal, and a very slight increase of the weld, as well as a notch-free seam. The weld metal is little affected by steel impurities. Due to the double coating the stick electrode is excellently suited for root- and out-of-position welding. Recovery 120%, H2 content < 8 ml/100g.

Mechanical properties of the weld metal

Yield strength R _e MPa	Tensile strength R _m MPa	Elongation A%	Impact strength K _v Joule
> 400	> 510	> 22	80

Welding instruction

Ignite the electrode and stay at the ignition point until the electric arc is fully stabilised. Keep a short arc during the welding process. Hold stick electrode vertical to the weldment with slight weaving. Re-drying: 2 - 3 h at 250 - 300°C. Only use dry stick electrodes.

Current type

(= +)

Welding positions



Availability / Current adjustments

Electrodes	Ø x L (mm)	2.4mm (3/32") x 350	3.2mm (1/8") x 350	4.0mm (5/32") x 450	5.0mm (3/16") x 450	6.0mm(1/4") x 450
Amperage	(A)	80-100	110-150	140-200	200-260	210-350