

ZULFI E 7018-1

Brand Name & Classification

AWS/ASME SFA-5.1 E 7018-I
DIN 8529: E SY 42 76 Mn B
EN 499: E 42 6 B 42 H5

Approvals Grade

ABS
DNV
BV 5Y40H5
GL
LRS

Properties

Electrode for producing crack free and tough welded joints, also suited for welding steels having a carbon content of up to 0.6 %. The weld metal has very low hydrogen content and is resistant to ageing. Good gap bridging properties. Welds are of X ray quality. Has good toughness properties up to -60°C .

Application

Unalloyed structural steel: St33 to St52-3, St50-2 to St60-2
Boiler plates: HI, HII, 17Mn4
Pipe steels: St52.4, St35.8, StE210.7 to StE360.7 1 including corresponding TM grades
Fine grain structural steels: StE255 to StE 355, WstE255 to WstE 355
Shipbuilding steels: A, B, D, E
Cast steel: GS-38 to GS-52

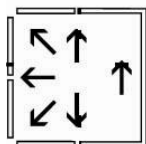
Weld Metal Analysis Typical values

Carbon: 0.06
Silicon: 0.30
Manganese: 1.45

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>420 N/MM ²	500 – 640 N/mm ²	> 22 %	180 J at +20 ⁰ c
			60 J at -60 ⁰ c

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	350	70-100
3.2	400/450	90-140
4.0	400/450	140-190
5.0	400/450	190-250