

## ZULFI E7018-1 H4R

### CLASSIFICATION

AWS	A5.1	E 7018-1 H4R
EN	499	E 42 6 B 42 H 5
DIN	1913	E SY 42 76 Mn B5

### APPROVALS

ABS	4Y40H5
BV	4Y40H5
DNV	4Y40H5
GL	4Y40H5
LRS	4Y40H5

### GRADE

### PROPERTIES

Electrode for producing crack free and tough welding steel having a carbon content up to 0.6 %. The Weld metal has very low hydrogen content and is resistance to ageing. Good gap bridging properties. Welds are of X-ray quality. Has good toughness properties up to -60 °C. It gives excellent arc stability, arc smoothness and easy slag removal properties in all position. Absorbed moisture content tested and it has passed upto 12 Hrs.

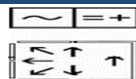
### APPLICATIONS

Welding of storage tanks, offshore platform construction, pipes, pressure vessels, boilers, bridges and heavy structures subject to dynamic loading and mechanical restraint. Suitable for joining steels like ASTM S-414M Gr C & D A414/SA. Gr 55 and Gr60 steels of S-516/516M.

### CHEMICAL ANALYSIS [TYPICAL VALUES IN %]

C	Mn	Si	P	S		
0.06	1.45	0.30	0.010	0.010		

### CURRENT CONDITION & WELDING POSITION



### ALL-WELD METAL MECHANICAL PROPERTIES

HEAT TREATMENT	YIELD STRENGTH (MPa)	TENSILE STRENGTH (MPa)	ELONGATION %	IMPACT STRENGTH
As Welded	≥ 420	500 - 640	≥ 22	180J at +20 °C 80J at -60 °C

### PACKING DATA

DIAMETER (MM)	LENGTH (MM)	CURRENT (A)	WEIGHT PER PACKET (KG)	NO. OF PACKETS PER CARTON
2.6	350	70-100	2.5	8
3.2	400 / 450	90-140	5.0	4
4.0	400 / 450	140-190	5.0	4
5.0	400 / 450	190-250	5.0	4