

SUPERCITO 7018 S is a basic coated MMA electrode for producing crack-free and tough welded joints. Designed for highly restrained work with static and dynamic loadings. The weld metal has good ISO-V toughness to -50°C. Very low hydrogen content after re-drying.

SUPERCITO 7018 S is suitable for unalloyed steels with low purity or higher carbon content, <0.4%C, and for buffer layers. Good welding characteristics, suitable for root passes and positional welding, welds are of X-ray quality. Material to be welded: EN 10025-3 S185, S235, S275, S355: P235, P265, P335; S275, S 335, S420.

Very low diffusible hydrogen content, high impact toughness down to - 50°C. Efficiency 120%. DC and AC, welding current.

Classification	
EN ISO	2560-A: E 42 5 B 32 H5
AWS	A5.1: E 7018-1 H4

Approvals	Grade
ABS	3YH5
BV	3YH5
DB	●
DNV-GL	4Y40H5
LRS	3YmH5
TÜV	●

CE

## Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05	1.2	0.4	≤ 0.020	≤ 0.015

## All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
				-20 °C	-30 °C	-50 °C
As Welded	≥ 420	510-640	≥ 24	≥ 150	≥ 120	≥ 70

## Materials

S(P)235-S(P)420; GP240-GP280; L245-L360

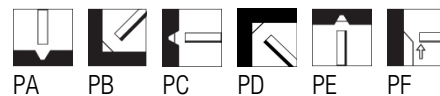
### Storage

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360°C for 2 hours, 5 times max.

### Current condition and welding position

AC; DC+



## Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX		VPMD	
				PC	Code	PC	Code
2.5	350	65-95	21.4	195	W000258277	85	W000258282
3.2	350	100-135	35.0	120	W000258278	55	W000258283
3.2	450	85-135	44.4	120	W000258279	55	W000258284
4.0	450	110-210	66.5	85	W000258280	40	W000258285
5.0	450	170-240	103.8	55	W000258281	25	W000258286