

Ferex 7018 LT



A basic coated low hydrogen electrode combining good all positional running characteristics with consistent weld metal properties down to -30 deg.c.

Classifications:	SFA/AWS A5.1:E7018, EN ISO 2560-A:E 42 4 B 32 H 5
Approvals:	ABS 3Y, BV 3YH15, CE EN 13479, DNV-GL 3 YH10, LR 3YH15, VdTÜV 03862

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC-(+)
Alloy Type:	C/Mn
Coating Type:	Basic

Deposition Data						
Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	75-110 A	23 V	0.64 kg	67.0	59 sec	1.00 kg/h
3.2 x 450 mm	110-150 A	21 V	0.66 kg	31.0	87 sec	1.50 kg/h
4.0 x 450 mm	150-200 A	22 V	0.66 kg	20.0	92 sec	2.00 kg/h
5.0 x 450 mm	190-260 A	23 V	0.68 kg	14.0	95 sec	3.10 kg/h