



## FEAT CRAFT Mild Steel 7018 Welding Electrode

**EXCELLENT WELDING PERFORMANCE AND SATISFACTORY IN VARIOUS WELDING POSITION**



### SPECIFICATION

**AWS : A5.1 / E7018 (HIGH TENSILE STRENGTH MILD STEEL WITH LOW HYDROGEN POTASSIUM)**

### MECHANICAL OF PROPERTIES OF DEPOSITED METAL

	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
<b>AWS E7018 Requirement</b>	Min 375	Min 490 - 660	Min 22
<b>Typical Value</b>	440	540	30

### CHEMICAL COMPOSITION – AS WELDED

	C	Mn	Si	S	P	Cr	Ni	Mo	V
<b>AWS 70183 Requirement</b>	Min 2.00	Min 1.2	Min 1.00	Min 0.035	Min 0.040	Min 0.20	Min 0.30	Min 0.30	Min 0.08
<b>Typical Value (%)</b>	0.070	0.41	0.26	0.021	0.023	0.047	0.022	0.010	0.014

### CHEMICAL COMPOSITION – AS WELDED

Diameter x Length	Weight (kg)		Packet per Carton	Product Number
	Packet	Carton		
2.5mm x 300mm	5	20	4	DN23-325
3.2mm x 350mm	5	20	4	DN23-332
4.0mm x 400mm	5	20	4	DN23-340
5.0mm x 400mm	5	20	4	DN23-350

### RECOMMENDED WELDING CURRENT (DC / AC)

Diameter x Length		2.5 X 300	3.2 X 350	4.0 X 400	5.0 X 400
	<b>CURRENT (A)</b>	F, H	70 – 100	100 - 140	140 -170
V, OH		60 -70	80 - 110	130-150	-

### Welding Position

**ALL POSITION**



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