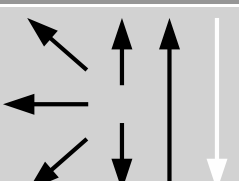


Classification						
AWS A5.1		AWS A5.1M		EN ISO 2560-A		
E7018 H4R		E4918H4R		E 42 5 B 42 H5		
Characteristics and typical fields of application						
<ul style="list-style-type: none"> • Basic covered electrode with very good welding characteristics including out of position work. • Weld metal recovery about 115%*. • Crack-free weld metal when welding high-carbon steels. • Suitable for use in tank construction, boiler and pressure vessel manufacturer, apparatus engineering, vehicle manufacture, offshore applications and ship building. 						
Base Materials						
S235JRG2 – S355J2, E295, E335, C35; boiler steels P235GH, P265 GH, P295GH, P355GH; fine grained structural steels up to S420N; shipbuilding steels A, B, D, E; offshore steels; pipe steels P265, P295, L290NB – L415NB, L290MB – L415MB, X42 – X56; cast steels GS-38, GS-45, GS-52; ageing resistant steels Ast35 – Ast52; SA 516 Gr 60, 65, 70; SA333 Gr 6.						
Typical analysis of all weld metal (wt.-%)						
C	Si	Mn	P	S		
0.08	0.50	1.40	0.009	0.01		
Mechanical properties of all-weld metal						
Heat treatment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+ 20 °C	- 40 °C	
As Welded	490	560	30	160	55	
Operating data						
		Polarity DCEP	Note: * metal recovery rate may vary slightly with higher diameter Re-drying if necessary : 300 – 350°C min. 2h Electrode Identification : BOHLER FOX S EV 50/7018-H4R			
Approvals						
ABS,LR,DNV,BKI,IBR						
Size, Packaging and Electrical Operating Data						
Size (mm)		Carton Pack		Vacuum Pack		Amperage (A)
Ø	Length	Kg / Pack	Kg / Box	Kg /Vac.	Kg / Box	
2.50 x 350	350	5.0	20.0	2.0	12.0	80 – 110
3.25 x 350	350 / 450	5.0	20.0	2.0	12.0	100 – 145
4.00 x 350	350 / 450	5.0	20.0	2.0	12.0	140 – 200
5.00 x 450	450	5.0	20.0	2.0	12.0	190 – 250