



ISO 9001:2015  
Quality Certified  
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# SAMURAI®

## ARC Welding Electrodes for MILD STEEL

### E7018 Low hydrogen Samurai Brand Electrode

Special welding electrode for heavy structure and bridges.

Classification- AWS A/SFA5.1, Is814

#### Key features: -

(1) Basic coated Iron powder electrode (2) All Position operating characteristic (3) Radiographic weld deposit (4) Metal recovery approx. 115% (5) Can operate AC/ DC EP (70 OCV). (6) high penetration on weld metal. (7) Easy slag removal (8) Excellent striking & restriking quality

#### Chemical Composition of weld metals:

C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	V%
0.12 Max	1.25 Max	0.50 Max	0.035 Max	0.035 Max	0.2 Max	0.3 Max	0.3 Max	0.08 Max

#### Mechanical Properties of Weld metals:

UTS (N/mm <sup>2</sup> )	Y.S (N/mm <sup>2</sup> )	Elongation (%) 4d	CVN Impact (J) at Zero degree centigrade
560	480	28	66

**Typical Applications: -** Pressure vessels, pipes, construction, Construction equipment, Bridges, Heavy structure, storage tank, Joining of Low & Medium Carbon steel grade.

**Redrying Condition: -** 250-300 degree centigrade (min) for one hour.

#### Parameter's – Packing data:

Diameter x L(mm)	Current (Amp)	Wt./packet (Kg)	Packet/Carton (No)	Net Weight/Carton(Kg)
2.5mm x 350mm	50 - 90	5	4	20
3.2mm x 350mm	100 - 130	5	4	20
4.0mm x 350mm	140 - 180	5	4	20

Approved by: NHS  
An ISO 9001:2015 Company from IQNET Austria

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