

CARVER 7018

BASIC COATED LOW HYDROGEN - IRON POWDER ELECTRODE

FEATURES

CARVER 7018 is a basic coated low hydrogen iron powder electrode suitable for welding heavy structures, high tensile strength jobs where impact strength at sub-zero temperatures are required. With an increased metal recovery due to the presence of iron powder, enhances the welder to complete the job faster. The basic coated formulation ensures a defect free radiographic quality weld. The superb and well established flux formulation ensures excellent performance of the electrode in AC/DC (+) in all welding positions except vertical down. We can supply flux cored wires also.

APPLICATIONS

CARVER 7018 is suitable for all sorts of joining, repairing and fabrication of structural works medium and high tensile steels of grade 540 N/mm². The applications include; welding of structures, highly restrained joints, bridges, railway coaches & wagon, plants, ships, tugs, barges, trawlers, dredgers, storages, tanks, boilers, pipelines, grills etc. Recommended where toughness and reliability of weld joint are of prime importance.

OPERATIONAL CHARACTERISTICS

- Uniform and soft metal transfer.
- Easy to control weld pool and slag.
- Suitable in AC70 V/DC (+) and AC too.
- Excellent Impact Resistance and Ductility.
- High tensile strength and excellent toughness in sub-zero temperatures.
- Suitable for highly restrained joints

TECHNICAL DATA

Yield Strength	: 480 N/mm ²
Tensile Strength	: 540 N/mm ²
Elongation	: 22 - 28 %

RECOMMENDED CURRENT RANGE

ELECTRODES				
SIZE (mm)	2.5	3.25	4.00	5.00
AMPS	70-100	100-140	150-190	200-250

FLUX CORED WIRES				
SIZE (mm)	1.2	1.6	2.00	2.4
AMPS	140-280	200-320	240-340	330-370

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

ELEMENT	C	Mn	Si	S	P	Mn+Ni+Cr+V
PERCENT	0.07	1.00	0.54	0.016	0.020	<1.75%

PACKING DETAILS

1 CARTON	: 5 KG
1 BOX	: 4 CARTONS