



ULTRAWELD

E 7018

LOW HYDROGEN BASIC COATED ELECTRODES

Conforms to Standard AWS 5.1-91 E7018;
BS 639-1976 E5154B1 1026H & JIS D5016

FOR
PERFECT
WELDING



PREMIUM QUALITY WELD & LOW STAB LOSS

The basic use of Ultraweld is for welding lightweight to heavy steel, very thick and strong joints, medium and high carbon steel, medium tensile structural steel, low-alloy based engineering steel, low-temperature alloys, hard steel, cast steel, and high-temperature sulphur-added steel. These electrodes can be used effectively for hydro-penstock and similar site applications because of their amazing performance and welding capabilities under any condition. The work done by Ultraweld is so perfect that cracks cannot be seen even through x-rays.

USAGE:



High Carbon Steel



Heavy Steel



Very Thick and Strong Joints

KEY FEATURES OF ULTRAWELD:

- High thickness flux coated
- Less spatter, thus creates less smoke
- Excellent weld bead and can be easily struck
- Excellent strength and firmness
- High metal recovery





TYPICAL MECHANICAL PROPERTIES:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (J)	Elongation (LO=5d0) (%)
Lowest 515	510–550	(Min) 112 at –20 degree celsius	Lowest 25

TYPICAL CHEMICAL COMPOSITION OF WELDED STEEL (%)

(%) Carbon(C)	Manganese(Mn)	Silicon(Si)	Sulphur(S)	Phosphorus (P)
0.10	0.80	0.40	0.03	0.03



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Type of Current: AC/DC (Minimum OCV 55 Volt)

OPERATING & PACKING INFORMATION:

Dia (mm)	Length (mm)	Weight Per Package (KG)	Proposed Current Range (A)
2.50	300	2	65–100
3.20	350	3	95–150
4.00	350	3	145–220

RULES FOR STORAGE:

Keep the electrodes in a dry place. Before using, heat in the oven at 350°C temperature for 90–120 minutes till dry again and keep in a hot box of 100–120°C temperature.

WARNING:



Avoid inhaling of welding fumes and gases for health



Welding Arc rays can injure eyes & burn skin



Read and understand safety instructions & practices before use



Always weld in an open & well ventilated space with sufficient airflow



Wear protective safety gear for your eyes, ears & body



Always be careful when handling electrical equipment

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