



## RASI E 7018-1 LH

premium

BASIC COATED LOW HYDROGEN  
ELECTRODES

### TECHNICAL SPECIFICATION SHEET

#### CHARACTERISTICS

RASI E - 7018-1 LH is a basic coated iron powder Low hydrogen type electrode giving radiographic welds with excellent impact properties at sub zero temperatures. Deposits weld metal with highest Radiographic soundness. Addition of Iron powder permits higher current to be used resulting in improved arcing characteristics. High notch ductility at sub zero temperatures. Touch welding possible. Deposition efficiency about 115%

#### APPLICATIONS

Boilers, pressure vessels, Rigid structures, Components under dynamic loading ship building, Heavy sections, Carbon steels, free cutting steels, Penstocks, Blast Furnace Shells, Rail Wagons and Coaches.

#### CLASSIFICATIONS

IS. : 814 EB5629H3JX

AWS : A5.1 E-7018-1

#### CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.10%	Silicon - 0.75%
Manganese - 1.60%	Sulfur - 0.03%
Phosphorus - 0.03%	

Note: Single Values shown above are maximum

#### MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm<sup>2</sup>) - 510 - 650  
 Yield Strength (N/mm<sup>2</sup>) - 360 MIN.  
 Elongation % - 20% MIN.  
 CVN Impact at -46°C - 27 J MIN.

#### WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 100 Amps  
 Ø 3.15 mm - 100 - 140 Amps  
 Ø 4.00 mm - 140 - 190 Amps  
 Ø 5.00 mm - 190 - 240 Amps.  
 Ø 6.30 mm - 240 - 300 Amps.

**\*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- [info@rasielectrodes.com](mailto:info@rasielectrodes.com)**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

[www.rasielectrodes.com](http://www.rasielectrodes.com)

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