

# X BOND

AWS A/SFA 5.1 **E7018**

C-Mn STEEL (Low Hydrogen)

**CLASSIFICATION:**

ISO 2560-A  
E 42 2 B 32

**KEY FEATURES:**

- Basic coated electrode
- Low hydrogen iron powder type
- Tough and ductile weld
- Radiographic weld deposit
- Deposition efficiency is typically 110%
- All position capability
- Pipe welding in 5G and 6G positions

**APPROVALS:** ABS/IRS/LRA/IBR

**TYPICAL APPLICATIONS:**

- Structural welding
- Storage tanks
- Boilers, Pressure vessels
- Bridges, Pipes
- Joining steel ASTM SA 414/414M Gr.C/D/E, SA 516/516M Gr.55/60

**TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:**


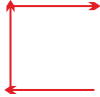
C	Mn	Si
0.1	1.0	0.5

**MECHANICAL PROPERTIES OF ALL WELD METAL:**

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact - 30°C, J
Typical	As Welded	525	440	26	55
Specification		490 min	400 min	22 min	27 min

HaDiffusible H2 Content: <5 ml/100 gm

**PARAMETERS - PACKING DATA:**

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 <b>AC (70 OCV)/ DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions Except Vertical Down: 
3.15 x 450	100-130		
4.0 x 450	140-180		
5.0 x 450	180-240		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each. Also available in vacuum packing

**EQUIVALENT:**

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Automig 70S-3	Tigfil 70S-2	Automig FC 71T-5	Automelt B71	Automelt EM12K
Automig 70S-6	Tigfil 70S-3		Automelt B31	Automelt EH14
	Tigfil 70S-6			