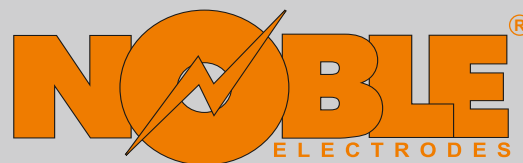


NOBLE - 7018

Mild Steel Low Hydrogen type Radiographic
Quality Electrodes



CLASSIFICATION

IRS - 3Y40HH
IS - 814: EB5426H3JX

AWS - A5.1: E7018

Characteristics : **NOBLE - 7018** is a heavy coated iron powder type electrode gives a smooth arc, good penetration and very less spatters. It is easy to operate in all position except vertical downward for radiographic quality welds. It produces uniform and finely rippled welds of superior finish. The weld metal is extremely ductile and crack resistant. The Effective electrode efficiency is more than 110%. The electrode operates on AC (70 V OCV) as well as DC (+) power.

Applications : **NOBLE - 7018** is suitable for the welding of high tensile steels such as blast furnace steel work, pressure vessels, storage tanks, wagon building, pipe lines, furnace shells, bridges, ship hulls, root runs in heavy joints etc.

Mechanical Properties

Mechanical Tests	Required Values
Yield Strength	400 N/mm ² (Min.)
Tensile Strength	510 - 610 N/mm ²
Elongation	25 % (Min.)
Impact (CVN) at -20°C	47 J (Min.)
Impact (CVN) at -30°C	27 J (Min.)

* If Moist: Re-dry at 250°C For 2 Hrs.

Weld Metal Chemistry (%)

Elements	C	Mn	Si	P	S	Ni	Cr	Mo	V
Range	0.10 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.30 Max	0.20 Max	0.30 Max	0.08 Max

Packing Specifications & Current Condition

Size (mm)	Pkts. / Case	Pcs. / Pkt	Current (Amp.) AC (70V) DC (+)
2.50 x 350	04	200	70-100
2.50 x 350	05	4 Kg.	70-100
3.15 x 350	04	125	100-140
	05	4 Kg.	
3.15 x 450	04	125	100 - 140
4.00 x 350	05	4 Kg.	140 - 180
4.00 x 450	04	70	140 - 180
	04	5 Kg.	
5.00 x 450	04	55	170 - 240
	04	5 Kg.	

"Noble – Characterized by all Excellent Qualities"