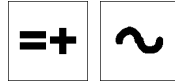


**Coating type:**  
Basic

**Arc voltage:** 65V

**Current:**



**Tip colour:**

-

**Welding positions:**



**Printing:**

BASIC / E7018

Basic is our general purpose low hydrogen electrode for all welding positions, except vertical down position. Weld metal recovery around 120%. The electrode is characterised by a smooth, quiet arc, very low spatter, easy slag removal and excellent mechanical properties (down to -40°C). Typical applications include shipbuilding, general constructions and offshore constructions.

**Base materials to be welded:**

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-EStE355, StE285TM-EStE355TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0-St52.4, St45.8, X42-X60, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

**Applications:**

- Shipbuilding & Offshore
- General fabrication & construction
- Repair & Maintenance

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / Brazing
-	K 60	Hilcord 51	Fer SG 2	H100 / HW530	-

**Chemical composition, wt. % weld metal – typical:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,07	1,2	0,35	≤ 0,020	≤ 0,020							

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 420	≥ 510	≥ 25	-40°C ≥ 47

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	21,0	65-110
3,2	350	39,1	100-145
4,0	450	72,1	135-200