

TRUSTARC™

KOBE-7018-1

Iron Powder, Low Hydrogen Type Electrode



Features

Workability

- ◆ Much iron powder contained in the coating gives high efficiency.
- ◆ **TRUSTARC KOBE-7018-1** produces the weld metal of excellent toughness and crack resistibility because of the characteristic peculiar to the low hydrogen type electrode.
- ◆ Good weldability and bead appearance with both AC and DC.
- ◆ All position welding for 490MPa class high tensile steel is performed, in the field of shipbuilding, pressure vessel, machine and steel structural fabrications.

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Available sizes and recommended welding current (AC, DC-EP)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	400	450
Welding current (Amp)	F, HF, H	70~100	90~130	130~180	180~240
	VU, OH	65~95	80~120	110~170	-

Notes on usage

- ◆ Drying the electrode at 350°C~400 °C for 1 hr before use.
- ◆ Keep the arc length as short as possible.
- ◆ Use the back-step method or a tap plate at the time of arc starting in order to prevent blowholes.
- ◆ Use the wind screen against strong wind.
- ◆ Do the pre-heating properly when there is fear of cracking at the time of welding high restrained or high carbon equivalent steel.

Typical mechanical properties of all weld-metal

	Y.P (MPa)	T.S (MPa)	E.I (%)	Impact value (J)		
				-60°C	-46°C	-30°C
As welded	493	563	34	115,163,123 Avg. 134	149,178,191 Avg. 172	177,194,189 Avg. 187
PWHT (620°Cx4 hr)	433	530	39	152,177,185 Avg. 171	211,172,198 Avg. 194	254,267,278 Avg. 266
Guaranty	≥ 400	≥ 490	≥ 22	-	≥ 27	-

Typical chemical composition of all weld-metal (mass %)

	C	Si	Mn	P	S	Ni	Cr	Mo	V	I*
Typical (DCEP)	0.06	0.38	1.54	0.011	0.004	0.01	0.03	<0.01	0.01	1.58
Guaranty	≥0.15	≥0.75	≥1.60	≥0.035	≥0.035	≥0.30	≥0.20	≥0.30	≥0.08	≥1.75

Note :I = Mn+Ni+Cr+Mo+V

Diffusible Hydrogen Content

Diffusible hydrogen content (ml/100g)				
2.2	2.7	2.5	3.1	Avg 2.6

Shipping Approval

Approvals List			
LR	ABS	DNV-GL	BV

DISCLAIMER

•Information in this booklet such as chemical compositions and mechanical properties is typical or example for explaining the features and performance of our products, and it does not guarantee otherwise specified.
 •Information contained herein is subject to change without notice. Please kindly contact KOBELCO for latest information

➤ For Technical Consultation, please contact **Technical Service.**

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