



GEMINI 7018-A1

Typical Applications And Characteristics

GEMINI 7018-A1 is a basic coated hydrogen controlled electrode for welding low alloy and creep-resisting Mo-steels. Suitable for boiler, storage vessel and pipeline construction ; for service temperature up to 525 °C. Low spatter loss, read slag detachment.

Typical All-Weld Metal Properties

Composition		Mechanical			
(%)		(a) As-welded, (b) Stress relieved (580 °C/15h/oven)			
		(a)	(b)		
C	0.06	Yield strength	>470	>450	N/mm ²
Mn	0.80	Tensile strength	550-650	520-600	N/mm ²
Si	0.50	Elongation (5xd)	22	22	%
Mo	0.50	Reduction of area	65	63	%
		Impact strength ISO-V@+20 °C	>140	>140	Joule
		Yield strength (0.2%)			
		at elevated temperatures :@500 °C@350	>350	N/mm ²	

Typical welding current

AC or DC +/-					
Ø/L (mm)	2.6/300	2.6/350	3.2/350	4.0/400	5.0/400
Current min/max (A)	60/90	60/90	70/140	110/180	160/250

International Standard		Color	End	Pink
AWS A5.5	E 7016-C1	Coding	Side	-
		Printing	G-7016-C1/E 7016-C1	
	-	Welding	Flat, horizontal,	
	-	Positions	vertical-up and overhead	