

GEMINI 7018-1

AWS/SFA5.1E7018-1

Typical Applications And Characteristics

GEMINI 7018-1 is a basic coated hydrogen controlled electrode for high mechanical property requirements and crack resistance. Also suitable for crack-resistant joint weld on higher carbon steels. The double coating provides very stable arc characteristics with excellent all-position weldability. Low spatter loss, ready slag detachment and regular bead appearance. COD tested for offshore applications.

Typical All-Weld Metal Properties				
Composition (%)		Mechanical		
C	0.06	Yield stress	470	N/mm ²
Mn	1.27	Tensile strength	560	N/mm ²
Si	0.30	Elongation	29	%
		CVN Impact Energy	90 Joule	@-46 C

DC +					
∅/L (mm)	2.6X300	3.2X350	4.0X400	5.0X400	-
Current min/max (A)	60-100	90-140	140-190	180-240	-

Typical welding current			
Approval	Color	End	White
ABS LR	Coding	Side	Silver
	Printing	G-7018-1/E 7018-1	
	Welding Positions	Flat, horizontal, vertical-up and overhead	