

## MMA Electrodes C-Mn and low-alloy steels

SUPERCITO 7018 S is a basic coated MMA electrode for producing crack-free and tough welded joints. Good welding characteristics, suitable for root passes and positional welding, welds are of X-ray quality. The weld metal has good ISO-V toughness to -50°C. Suitable for unalloyed steels with low purity or higher carbon content, <0.4%C, and for buffer layers. Very low hydrogen content after re-drying.

Classification	
EN ISO	2560-A: E 42 5 B 3 2 H5
EN	499: E 42 5 B 3 2 H5
AWS	A5.1: E 7018-1 H4

Approvals	Grade
ABS	3H10-3Y
BV	33YHHH
DB	●
DNV	4Y40 H5
GL	4Y40H5
LRS	33Y H5
TÜV	●

CE

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05	1.2	0.4	≤ 0.020	≤ 0.015

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)		
				-20 °C	-30 °C	-50 °C
As Welded	≥ 420	510-640	≥ 24	≥ 150	≥ 120	≥ 70

### Materials

S(P)235-S(P)420; GP240-GP280; L245-L360

### Storage

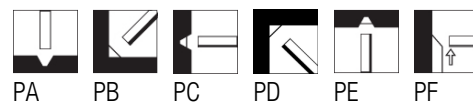
Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 times max.

HD ≤ 10: Re-dry at 300-350 °C for 2 hours, 5 times max

### Current condition and welding position

AC; DC+



### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		DRYF		VPMD	
				PC	Code	PC	Code	PC	Code
2.5	350	70-95	21.4	185	●	28	●	85	●
3.2	350	100-135	34.2	115	●	22	●	55	●
3.2	450	100-135	44.4	115	●	22	●	55	●
4.0	450	130-180	66.5	80	●	18	●	40	●
5.0	450	170-240	103.8	55	●			25	●