



## MAC TRODE E6718

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### ■ **Description & Applications :**

High quality superior all positional low hydrogen Manual Metal Arc welding electrode using a silicon free, low nitrogen, high purity C:Mn core wire with concentrically extruded, moisture resistant chemically basic flux with a controlled iron powder addition, to provide 120% metal recovery. Welds are of smooth appearance, ductile and of high radiographic quality. For welding mild and medium tensile steels and for BS4360 1972 steels where low hydrogen levels and crack resistant weld metal are required. The electrodes are particularly suitable for welding heavy sections subject to high levels of resistance and for welding problem steels with high sulphur content. Recommended for unalloyed C:Mn ferritic steels with high sub-zero toughness requirements, e.g:- Charpy values down to  $-60^{\circ}\text{C}$ . CTOD values at  $-10^{\circ}\text{C}$ . Used to best advantage for welding thick sections either on site or in fabrication shops. Excellent all positional weldability.

### ■ **Related Specification :**

AWS E7018-G

### ■ **Typical All Weld Metal Chemical Analysis:**

C	Mn	Si	S	P
0.08	1.60	0.30	0.010	0.015

### ■ **Typical All Weld Mechanical Properties :**

<b>As Welded</b>		<b>Min</b>	<b>Max</b>
Tensile Strength	N/mm <sup>2</sup>	510	560
0.2% Proof Stress	N/mm <sup>2</sup>	420	460
Elongation on 4d	%	20	25
Reduction of area	%	-	70
Impact energy 0°C	Joules	47	110

### ■ **Current:**

AC/DC+ (OCV 70 amps) min

### ■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-90	90-130	130-180	160-220	250-300

### ■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at  $150^{\circ}\text{C}$  before use.