



Mild Steel Stick Electrodes

Code & Specification

ASME SFA/AWS A5.1 E7018-1

Description

BLUME® E7018 is a mild steel stick electrode. Clear weld puddle without slag interference. Flat bead profile.

Applications

BLUME® E7018 is used in several industries such as power generation, petrochemical, pressure vessels and pressure piping. Typically used for mild steel welding.

Mechanical Properties

	As-welded
Yield Point, MPa	440 - 550
Tensile Strength, MPa	540 - 600
Elongation, %(L=4d)	> 27

Charpy V-Notch Impact Properties

Testing Temp. (°C)	As-welded (J)
-29°C (-20°F)	27 min

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	S	P
0.06 - 0.08	1.20 - 1.50	0.40 - 0.60	0.01 - 0.02	0.01 - 0.02
Ni	Cr	Mo		
≤ 0.1	≤ 0.1	≤ 0.1		

Packaging

∅ x L	Wt./Carton	Carton/Box	Net wt./Box
2.5mm x 300mm (3/32" x 12")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
3.2mm x 350mm (1/8" x 14")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)
4.0mm x 400mm (5/32" x 16")	2.5 kgs (5.5 lbs)	8	20 kgs (44 lbs)

Suggested Welding Parameters

∅ x L	AC	DC±
2.5mm x 300mm (3/32" x 12")	80 - 120	70 - 110
3.2mm x 350mm (1/8" x 14")	100 - 160	90 - 160
4.0mm x 400mm (5/32" x 16")	130 - 220	120 - 220

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

3rd Floor, No. 23, 5th Cross, Koramangala 5th Block, Bangalore 560 095, India
Tel: +91 80 2528 3432 Email: info@blumenotics.com Web: www.blumenotics.com

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