



### UNIWEELD IND. DE ELETRODOS LTDA

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**COMMERCIAL NAME:** ESSEN MS 718 WB

**Revision:** 00

**STANDARD:** AWS A5.5: 2014 E 7018-G / ASME SFA5.5 E 7018-G Edition 2015

**Date:** 12/2018

Chemical characteristic of the deposited metal	C ND	Mn* 1.00% Min.	Si* 0.80% Min.	P 0.03% Max.	S 0.03% Max.	Ni* 0.50% Min.	Cr* 0.30% Min.	Mo* 0.20% Min.	V* 0.10% Min.	Cu* 0.20% Min.
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Note (\*): To meet the requirements alloy of the group G, the alloy must contain at least one of the elements listed in the table.

<b>APPLICATION FIELD</b>	It is a special electrode low hydrogen with basic coating. Deposit a special alloy with nickel, providing excellent properties mechanical and welding.															
<b>TECHNICAL CHARACTERISTICS</b>	Special basic coating low hydrogen electrode used for welding weathering steels in contact with atmosphere saturated in SO <sub>2</sub> . Suitable for welding the weather resistant steel with COLOR-MET PATINAX, YAM-TEM, NTU, SAC 50, etc.															
<b>MECHANICAL PROPERTIES</b>	<b>Tensile strength:</b> 490 MPa (min) <b>Yield strength:</b> 390 MPa (min) <b>Stretching:</b> 22% (Min)															
<b>OPERATIONAL FEATURES</b>	<b>Welding position:</b> Flat, Vertical, Horizontal and About head.															
	<b>Type of current:</b> CC +, CA -															
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø 2.50</th> <th>Ø 3.25</th> <th>Ø 4.00</th> <th>5.00 Ø</th> </tr> </thead> <tbody> <tr> <td><b>Amps (A)</b></td> <td>80-110</td> <td>110-140</td> <td>150-190</td> <td>200-250</td> </tr> <tr> <td><b>Packaging (kg)</b></td> <td>5</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </table>	Diameter (mm)	Ø 2.50	Ø 3.25	Ø 4.00	5.00 Ø	<b>Amps (A)</b>	80-110	110-140	150-190	200-250	<b>Packaging (kg)</b>	5	5	5	5
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<b>WELDING TECHNIQUE</b>	Thoroughly clean the area to be welded with grinder or mechanical brushing removing all traces of contamination, for scale, oils and oxides, regulate the amperage in relation to the diameter of the rod that will be used to maintain the short arc with the nozzle perpendicular to the metal base.															