

# X-BOND

## CLASSIFICATIONS

**AWS S/SFA 5.1** E7018

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

A basic coated, low hydrogen, iron powder type electrode with excellent deposition efficiency up to 110-115% approx. This welder friendly electrode has excellent arc stability and smoothness with very good deslagging property giving tough and ductile weld bead. All positional electrode giving X-ray quality welds with extraordinary operating characteristics. Can be used for pipe welding in 5G & 6G positions.

## TYPICAL APPLICATIONS

Perfectly suitable for structural welding applications. Welding of storage tanks, pipes, pressure vessels, boilers, etc. Suitable for joining steels conforming to ASTM specifications: C, D, E, grades of SA-414/SA-414M (P-No.1), Gr55, Gr60 steels of SA-516 / 516M (P.No.1)

## APPROVALS :

**ABS** 3YH5 **TOYO**

**LRA** 3Ym,H5 **MND**

**IBR** E7018

## CURRENT CONDITIONS: AC (70) or DC (+)

6.3	5.0	4.0	3.2	2.5
230-310	180-240	140-180	100-130	60-90

## WELD METAL CHEMISTRY, (%)

C - 0.10max S - 0.03max Mn - 1.60max P - 0.030max Si - 0.75max

## MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	(%) Elong. (L=4xd) 22 min	CVN Impacts, J -30°C 27 min
As-welded	490 min	400 min		

## PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Pcs per carton, Nos	50	75	111	231
Cartons / box	4	4	4	4
Pcs per box, Nos	200	300	444	924
Approx. Wt. of 1000 pcs,kg	98	66	45	22



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