

Classification								
AWS A5.1			AWS A5.1M			EN ISO 2560-B		
E7018-1H4R			E4918-1H4R			E 49 18-1A U H5		
Characteristics and typical fields of application								
<ul style="list-style-type: none"> Basic covered electrode with very good welding characteristics including out of position work. Particular good impact properties down to -50°C. CTOD tested at -10°C. Weld metal recovery about 115%*. Crack-free weld metal when welding high-carbon steels. Suitable for use in tank construction, boiler and pressure vessel manufacturer, apparatus engineering, vehicle manufacture, offshore applications and ship building. Very low hydrogen content in the weld metal (under AWS conditions HD≤4ml/100gm) Suitable for welding steels with low purity and high carbon content. 								
Base Materials								
S235JRG2 – S355J2, E295, E335, C35; boiler steels P235GH, P265 GH, P295GH, P355GH; fine grained structural steels up to S420N; shipbuilding steels A, B, D, E; offshore steels; pipe steels P265, P295, L290NB – L415NB, L290MB, X42 – X60; cast steels GS-38, GS-45, GS-52; ageing resistant steels Ast35 – Ast52; SA 516 Gr 60, 65, 70; SA333 Gr 6.								
Typical analysis of all weld metal (wt.-%)								
C	Si	Mn	P	S	Cr	Mo	Ni	Mn+Ni+Cr+Mo+V
0.08	0.50	1.40	0.009	0.01	< 0.05	< 0.05	< 0.05	1.4
Mechanical properties of all-weld metal								
Heat treatment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J				
	MPa	MPa	%	+ 20 °C	- 50 °C			
As Welded	490	560	30	190	100			
Operating data								
		Polarity DCEP	Note: * metal recovery rate may vary slightly with higher diameter Re-drying if necessary : 300 – 350°C min. 2h Electrode Identification : Bohler Fox S EV 50-1/7018-1H4R					
Approvals								
ABS,LR,DNV,BKI,IBR								
Size, Packaging and Electrical Operating Data								
Size (mm)		Carton Pack		Vacuum Pack		Amperage (A)		
Ø	Length	Kg / Pack	Kg / Box	Kg / Vac.	Kg / Box			
2.50	350	5.0	20.0	2.0	12.0	80 – 110		
3.25	350/450	5.0	20.0	2.0	12.0	100 – 145		
4.00	450	5.0	20.0	2.0	12.0	140 – 200		
5.00	450	5.0	20.0	2.0	12.0	190 – 250		