

Classification Of Electrodes For Welding Of Non-Alloys Steels As Per AWS A5.1/AE.1 M: 2004

E 7018						
Symbol	Type of Cover	Welding Position	Current Type	Elongation %Min.	Product	
					Symbol	Product
10	Cellulosic-Sodium Silicate	F, V, OH, H-fillet	DC (+)	22	G	Wire Electrodes
11	Cellulosic-Potassium Silicate	F, V, OH, H-fillet	AC-DC (+)	22	O	Oxy-Acetylene
12	Rutile-Sodium Silicate	F, V, OH, H-fillet	AC-DC (-)	17	E	Electric Arc Welding
13	Rutile-Potassium Silicate	F, V, OH, H-fillet	AC-DC (-) (+)	17	S	Submerged Arc Welding Wires
14	Rutile-Iron Powder	F, V, OH, H-fillet	AC-DC (-) (+)	17	T	Flux-Cored Wires
15	Basic-Sodium Silicate	F, V, OH, H-fillet	DC (+)	22	W	TIG Rods
16	Basic-Potassium Silicate	F, V, OH, H-fillet	AC-DC (+)	22	F	Submerged Arc Welding Fluxes
18	Basic, Iron Powder-Potassium Silicate	F, V, OH, H-fillet	AC-DC (+)	22		
19	Rutile, Iron Oxide-Potassium Silicate	F, V, OH, H-fillet	AC-DC (-) (+)	22		
20	Iron Oxide	F, H-fillet	AC-DC (-) (+)	22		
22	Iron Oxide	only for one-run welding	AC-DC (-)	0	1	All Welding Positions
24	Rutile-Iron Powder	F, H-fillet	AC-DC (-) (+)	17	2	Horizontal And Flat Welding Positions
27	Iron Oxide-Iron Powder	F, H-fillet	AC-DC (-) (+)	22	4	All Welding Positions Including Vertical Down Position
28	Basic, Iron Powder-Potassium Silicate	F, H-fillet	AC-DC (+)	22		
48	Basic, Iron Powder-Potassium Silicate	F, OH, H, V-Down	AC-DC (+)	22		
Symbol	Tensile Strength (Min)		Yield Strength (Min)			
	A5.1 (Ksi)	A5.1 M(N/mm ²)	A5.1 (Ksi)	A5.1 M (N/mm ²)		
60	60	430	48	330		
70	70	490	58	400		

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