

# Spark Platinum Type: Basic E 7018-1

## Description

Basic Coated, Iron Powder electrode with superior metal properties. Hydrogen level below 5ml / 100 gms and impacts down to – 46°C.

## Deposition Efficiency

115%

## Welding current

DC+, AC 70 V

## Application

- Dynamically loaded heavy structures
- With Impacts down to - 46C
- Pressure Vessels and Boilers
- Hortonspheres and Bullets
- Pipelines subject to low temperatures in 5G & 6G positions

Description	Size	Pcs/Kg
SPARK Platinum	2.50 X 350	42
SPARK Platinum	3.15 X 450	23
SPARK Platinum	4.00 X 450	15
SPARK Platinum	5.00 X 450	10

## Welding Parameters

Diameter	Length	Welding	Arc voltage
mm	mm	current, A	V
2.5	350	80 - 110	23
3.15	450	110 - 140	24
4.0	450	135 - 190	25
5.0	450	170 - 270	26

## Classifications

SFA/AWS A5.1	E7018-1
IS : 814	EB 5626 H3JX

## Typical all weld metal composition, %

C	Si	Mn
0.07	0.4	1.4

## Typical mech. properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	570
Elongation, %	28

## Charpy V

Test temps, °C	Impact values, J
-20	150
- 46	70

