ESAB 36H (SPL)



ESAB 36H (SPL) is a basic coated low hydrogen iron powder electrode for low temperature applications. It is an all positional electrode for welding medium tensile and fine grained carbon steels. The electrode exhibits very good mechanical properties after extended post weld heat treatment.

Classifications:	SFA/AWS A5.1:E7018-1
Approvals:	ABS E7018-1, IBR E7018-1, LR 4Y40mH15, PDIL E7018-1

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	AC, DC+
Diffusible Hydrogen:	< 5.0 ml/100g
Alloy Type:	C-Mn
Coating Type:	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	500 MPa	570 MPa	32 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-30 °C	135 J
As Welded	-40 °C	90 J
As Welded	-46 °C	75 J

Typical Weld Metal Analysis %

C	Mn	Si
0.07	1.30	0.30

Current Range

Diameter	Current
2.5 x 350 mm	60-100 A
3.15 x 450 mm	80-140 A
4.0 x 450 mm	100-190 A
5.0 x 450 mm	180-260 A