

Premium Low Hydrogen Arc Welding Electrodes

- Exceptional arc stability
- A low hydrogen controlled electrode
- Easy slag removal
- Welding high tensile & Carbon Steel
- All Positional

7018 is a smooth running basic type iron powder hydrogen controlled electrode used for all positional welding except vertical down. Deposited metal gives excellent mechanical properties, crack resistance and X-ray quality welds, suitable for welding mild steel, low alloy, medium tensile steels.

Current Type: AC or DC+

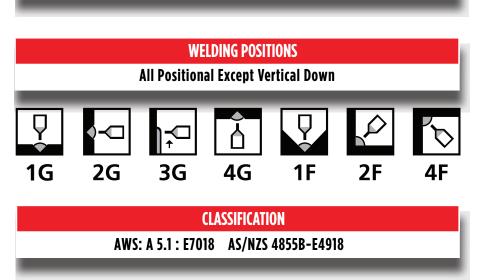
DIAMETER/LENGTH(mm)	2.5/350	3.2/350	4.0/350
Positions	Current(A)	Current(A)	Current(A)
F	70-100	100-140	150-190
V-UP/OH	60-90	80-120	110-150

TYPICAL MECHANICAL PROPERTIES OF DEPOSITED METAL

Tensile Strength 530 MPa Yield Strength 460MPa Elongation 33%

Recommended for DC +/- or AC (minimum 50 OCV) Voltage is determined by arc current and electrode arc length. Arc voltage shown is typical and is only to be used as a guide.

KEEP DRY Re-Drying/Conditioning temperatures of 300-350°C for 1 hour. Re-drying should be restricted to a maximum of three cycles.



Warning:

- Electric shock can kill
- Always wear eye protection
- Protect yourself and others around you

• Use enough ventilation for both arc and fume source

- Fumes and gases are dangerous to your health
- Arc rays can injure your eyes and burnskin