

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 |

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.

TYPICAL MECHANICAL PROPERTIES OF DEPOSITED METAL

Tensile Strength 530 MPa Yield Strength 460MPa Elongation 33%

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

WELDING POSITIONS

All Positional Except Vertical Down



1G

2G

3G

4G

1F

2F

4F

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 burn skin

CLASSIFICATION

AWS: A 5.1 : E7018 AS/NZS 4855B-E4918