

Easyarc™ 7018-1

Stick Electrode - Low Hydrogen / Iron Powder

Stick Electrode

Key Features

- ▶ Smooth running low hydrogen stick electrode
- ▶ Superb weld profiles in all positions
- ▶ Reliable impact properties to -46° C
- ▶ Vacuum Sealed Packaging

Conformances

AWS A5.1/A5.1M	E7018-1 / E4918-1
AS/NZS 4855-B	E4918-1A
Lloyd's Register	Pending

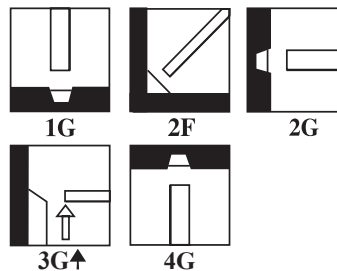
Diameter / Packaging

Diameter mm	Length mm	Outer Carton 9.6kg
2.5	350	7018-12550
3.2	350	7018-13250
4.0	350	7018-14050

Typical Applications

- ▶ Suitable for a wide range of mild and low alloy steels
- ▶ Used for general construction welding applications such as bridges, buildings and pressure vessels
- ▶ Low hydrogen electrode for critical applications

Welding Positions



Mechanical Properties - As Required per AWS A5.1 & AS/NZS 4855-B

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -46°C
Requirements - AWS	400 min	490 min	22 min	27
Requirements - AS/NZS	400 min	490 min	20 min	27
Typical Results - As Welded	435	545	27	106

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.09	1.25	0.38	0.024	0.009
	%Ni	%Cr	%Mo	%V	
Typical Results - As Welded	0.20	0.15	0.20	0.04	

Typical Operating Procedures

Polarity	Current (amps)		
	2.5 mm	3.2 mm	4.0 mm
AC / DC	50-85	80-140	130-180

