

7018-1 Carbon Steel Coated Electrode U.S. ALLOY CO. dba Washington Alloy 7010-G Reames Rd. Charlotte, NC 28216 www.weldingwire.com





in accordance with

ISO 9001

Cert # 05-R0925

ALLOY DESCRIPTION AND APPLICATION;

7018-1 is general low hydrogen mild steel all position electrodes recommended for mild – high carbon base metals, shipbuilding/barge offshore drilling rigs power, petrochemical and boiler plants. These rods are formulated to have quality welds with very easy slag removal or self-peeling, excellent welder appeal on those poor weldable steels. 7018-1 is easy to control which is used often for high impact level at -50°F while providing a stable arc with a flat to slightly convex fine ripple weld appearance.

TYPICAL WELDING PROCEDURES; DCEP, AC

Diameter	Amps (Flat)	Volts
3/32"	70-120	19-23
1/8"	90-160	23-27
5/32"	130-210	25-31

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

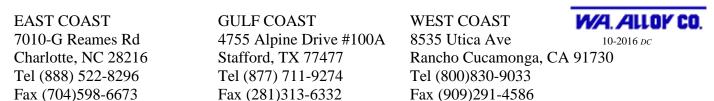
TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	Weld Metal		AWS Spec.	Weld Metal
Carbon	0.15	0.02	Chromium	0.20	0.01
Manganese	1.60	1.05	Molybdenum	0.30	0.01
Silicon	0.75	0.49	Vanadium	0.08	< 0.01
Phosphorus	0.035	0.010	Elongation in 2" (%)	22%	28%
Sulphur	0.035	0.014	Yield Strength (ksi)	58	67
Nickel	0.30	0.065	Tensile Strength (ksi)	70	79
Mn + Ni + Cr + Mo + V	1.50	Charpy	V-notch -50°F	20 ft·lbs min	73
			-20°F	20 ft·lhs min	95

AVAILABLE SIZES: TE 7018-1 = 3/32", 1/8", 5/32"

SPECIFICATIONS; ANSI/AWS A5.1 E7018-1, E7018

ASME SFA 5.1 E7018-1, E7018



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