7018-A1 Carbon Steel Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
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Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

American Welding Society
Sustaining Company Member

GAWDA
GASES AND WELDING DISTRIBUTORS ASSOCIATION

ALLOY DESCRIPTION AND APPLICATION;

E7018-A1 is an iron powder, low hydrogen electrode designed for welding low alloy, high tensile steel of 65,000 psi minimum yield strength and containing ½% Mo. This electrode offers the welder high deposition efficiency and produces a weld deposit with fine bead appearance, easy removal of slag, low spatter and medium penetration. E7018-A1 weld metal solidifies rather rapidly, making this electrode suitable for out of position welding.
E7018-A1 is typically used for the fabrication of carbon-molybdenum pipes, pressure vessels, boilers and tubing containing ½% Mo.

TYPICAL WELDING PROCEDURES; AC, DCEP

Diameter	Amps (Flat)	Volts
3/32”	60-150	21-26
1/8”	80-170	23-27
5/32”	110-220	25-31
3/16”	150-300	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	**0.12 max**	**0.06**	**Elongation in 2”(%)**	**25% min**	**28**
Manganese	**0.90 max**	**0.72**	**Yield Strength (ksi)**	**57 min**	**86**
Silicon	**0.80 max**	**0.49**	**Tensile Strength (ksi)**	**70 min**	**98**
Phosphorus	**0.03 max**	**0.012**	**Charpy V-notch**	**N/S**	**87**
Sulphur	**0.03 max**	**0.010**			
Molybdenum	**0.40-0.65**	**0.53**			

AVAILABLE SIZES: TE 7018-A1 = 3/32” , 1/8”, 5/32”
SPECIFICATIONS; ANSI/AWS A5.5 E7018-A1
ASME SFA 5.5 E7018-A1

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