



Quality Management System  
in accordance with  
**ISO 9001:2000**  
Cert # 05-R0925

# USA 7018AC Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



### ALLOY DESCRIPTION AND APPLICATION;

USA 7018AC are low hydrogen mild steel electrodes recommended for mild – high carbon base metals when low current or open circuit and small single-phase welders are used. These rods are formulated to have quality welds with very easy slag removal, excellent welder appeal on those poor weldable steels. 7018AC is easy to control which is used often for skip or tack welds providing a stable arc with a flat to slightly convex weld appearance.

### TYPICAL WELDING PROCEDURES; AC or DCEP

Diameter	Amps (Flat)	Volts
3/32"	70-130	21-26
1/8"	95-160	23-27
5/32"	120-210	25-31

Use a short arc – dragging with 10-15% from 90°

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. Lbs/hr 1.85, 2.60, 3.60 at 64, 69, 72 % efficiency

### TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES (AWS values are maximum)

	AWS Spec.	WELD METAL		AWS Spec.	WELD METAL
Carbon	0.15 max	0.05	Chromium	0.20 max	0.05
Manganese	1.60 max	1.45	Molybdenum	0.30 max	0.01
Silicon	0.75 max	0.47	Vanadium	0.08 max	0.03
Phosphorus	0.035 max	0.02	Elongation in 2" (%)	22% min	27%
Sulphur	0.035 max	0.01	Yield Strength (ksi)	58 min	71
Nickel	0.30 max	0.02	Tensile Strength (ksi)	70 min	83
Mn + Ni + Cr + Mo + V	1.75		Charpy V-notch at -20°F	20 ft.-lbs min.	42

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

**SPECIFICATIONS;** ANSI/AWS A5.1 E7018  
ASME SFA 5.1 E7018

**EAST COAST**  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

**GULF COAST**  
4855 Alpine Drive #190  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

**WEST COAST**  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586



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Warehouse Distribution Center – Portland, Oregon

Head Office – Puyallup,

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