

Weld 7018-1



Weld 7018-1 is a general - purpose basic DC + low Hydrogen electrode. Excellent for general purpose welding. Good impact values down to -45°C.

Classifications	SFA/AWS A5.1 : E7018-1H4 CSA W48 : E4918-1-H4
Approvals	CWB E4918-1-H4

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, AC
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Carbon Manganese
Coating Type	Basic covering

Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
AWS		
> 400 MPa (> 58 ksi)	> 490 MPa (> 71 ksi)	22 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
AWS	
-45 °C (-49 °F)	> 27 J (> 20 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si
0.06	1.5	0.5

Deposition Data

Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm (3/32 x 14 in.)	80-110 A	23 V	0.64	66	64 sec	0.9 kg/h (2.0 lb/h)
3.2 x 350 mm (1/8 x 14 in.)	110-140 A	23 V	0.62	41	72 sec	1.2 kg/h (2.6 lb/h)
4.0 x 450 mm (5/32 x 18 in.)	140-200 A	24 V	0.71	19	94 sec	2.0 kg/h (4.4 lb/h)
5.0 x 450 mm (3/16 x 18 in.)	200-270 A	24 V	0.72	13	94 sec	3.0 kg/h (6.6 lb/h)