



E7018-1

LOW HYDROGEN STEEL WELDING ELECTRODE

Excellent toughness at -50°F

TYPICAL APPLICATIONS

1. Heavy steel fabrication
2. Shipbuilding
3. Pressure vessels

CHARACTERISTICS

1. 1.120% deposition rate due to 25% high iron powder content
2. All positional welding capability
3. Good crack resistance and X-ray quality weld bead
4. 120J CVN impact value at -50°F

CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Mn	Si	S	P
0.06	1.28	0.50	0.012	0.010

MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Charpy V notch (J)
AW	550	455	28	-45°C 122

Note:

- ① Re-drying it at 350°C for 1-2 hours before using is necessary.
- ② Rust, oil, water, etc should be removed from the weld parts before welding.

SIZE AMPS

2.5mm 50-90A

3.2mm 90-130A

4.0mm 130-180A

5.0mm 180-240A

CLASSIFICATION

AWS A5.1 E7018-1
EN ISO2560-A E42 4 B 1 2

PACKING SPECIFICATION

*1kg PE bag
*5kg Cardboard Box

CURRENT TYPE

AC/DC+

AVAILABLE SIZES (DIA./LENGTH)

2.5mm*350mm
3.2mm*350mm
4.0mm*400mm
5.0mm*400mm

EQUIVALENT TO

Lincoln Excalibur 7018-1 MR
Atlantic CHE58-1
Hyundai S-7018.1

TecMig E7018