

Inweld 7018 Low Hydrogen – High Tensile

Alloy E7018
AWS A5.1 E7018

AC/DC + (reverse polarity)



Description and Applications:

General purpose, all-position electrode for welding carbon steel, free-machining steel, high tensile steel and low alloy steel.

Special low-hydrogen iron powder coating produces a quiet steady arc, low spatter and medium arc penetration. High deposition efficiency.

X-Ray quality weld deposits with a finely rippled smooth bead appearance and easy slag removal. Excellent charpy impact values at sub-zero temperatures (65 ft-lbs at -20 F).

Typical applications include tramp steels, structural and fabrication steels such as beams, angles, channels and plates, cast steels, process piping steels, cold rolled steel and shipbuilding steels.

Procedure:

Clean the weld area of all contaminants. Bevel heavy sections to a 60 Vee. Preheat the heavy sections at 300-500 F. Always use this electrode with DC+ (reverse polarity), however an AC machine with sufficient open circuit voltage can be used. For optimum performance we recommend a 7018AC electrode be used with an AC machine. Set your amperage to the proper range for the size electrode you are using, maintain a short arc length and hold the electrode at a 15 angle into the direction of travel. Weaving technique should be used but do not exceed 3 times the diameter of the electrode. Do not use the whipping technique as this will cause porosity in the weld deposit. Allow high carbon steels to cool slowly before removing slag.

Recommended Parameters	Diameter	Recommended Amperage	
		(F)	(V & O)
	3/32" (2.4mm)	55-85	50-80
	1/8" (3.2mm)	90-140	80-120
	5/32" (4.0mm)	130-185	110-180
	3/16" (4.8mm)	190-250	160-210

Warning

- This product, when used for welding or cutting, produces fumes or gases which may contain chemicals known to the state of California to cause birth defects (or other reproductive harm), and in some cases cancer. (California Health & Safety Code 25249.5 et seq.)
- Read American National Standards Z49.1, "Safety in Welding Cutting and Allied Processes," from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government Printing Office, Washington, DC 20402.

Fumes and Gases can be hazardous to you health.

- Before use, read and understand the materials Material Safety Data Sheet (MSDS), the manufacturer's instructions and your employers safety practices.
- If MSDS is not enclosed, obtain one from your employer.
- Keep your head out of the fumes. See section 5 of the MSDS for specific fume concentration limits.
- Use enough ventilation exhaust at the arc or both to keep fumes and gases from your breathing zone and general area. If needed, use a proper respirator.
- No hazards exist before this product is used in arc welding. Electric Shock can kill.
- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrical parts.
- ARC Rays can injure eyes and burn skin.
- Wear welding helmet with correct filter.
- Wear correct eye, ear and body protection.
- Welding can cause fire or explosion" Do not weld near flammable material.
- Watch for fire, keep extinguisher nearby.



Although reasonable care has been taken in the preparation of the information herein, Inweld Corporation extends no warranties, express or implied, makes no representations and assumes no responsibility as to the accuracy or suitability of information for application to purchaser's intended purpose or for consequences of it's use. Judgments as to the suitability of information for purchaser's purposes are purchaser's responsibility.