Sureweld 7018

Iron powder, low hydrogen type electrode for welding in all positions in single or multiple steps on plates of various structures. Recommended for steels ASTM A36, A285, A372, A53, A105 A515, A372 GRADE 55, 60, 70, A283, A516; A515, etc. Structures such as buildings, bridges, cranes, ships, railways, pipelines, storage tanks, high pressure vessels, construction rods, parts of heavy machinery, mining, sugar mills etc. Deposits with radiographic quality, its toughness exceeds those marked by the corresponding regulations in Charpy V – Notch test. Electrodes of very easy operation with direct current with positive electrode (+) DCEP, minimal sparking and little spattering, stable arc and easy handling by welders. Used for high productivity jobs in field and workshop works. Its slag cools quickly and is easily removed, the surface of the weld face is slightly convex and in fillet welds it can even be flat.

Specifications	
Classifications	ASME SFA 5.1 : E7018 AWS A5.1 : E7018
Approvals	ABS LR RCB
Industry	Mobile Equipment Railcars Automotive Ship/Barge Building Bridge Construction Civil Construction Industrial and General Fabrication

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

Welding Current	DC+
Alloy Type	Carbon Manganese

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	528 MPa (77 ksi)	607 MPa (88 ksi)	27 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	-30 °C (-22 °F)	145 J (107 ft-lb)

Typical Weld Metal Analysis %								
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**
0.15	1.60	0.75	0.035	0.035	0.30	0.20	0.30	0.08

Deposition Data			
Diameter	**Current**	**Deposition Efficiency (%)**	**Deposition Rate @ 90% I max**
2.4 x 356 mm (3/32 x 14.0 in.)	70-100 A	66.3 %	0.77 kg/h (1.7 lbs/h)
3.2 x 356 mm (1/8 x 14.0 in.)	90-160 A	71.6 %	1.18 kg/h (2.6 lbs/h)
4.0 x 356 mm (5/32 x 14.0 in.)	130-220 A	75.0 %	1.41 kg/h (3.1 lbs/h)