E7018 COVERED ELECTRODE

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NOMINAL COMPOSITION:
- Carbon: 0.08%
- Silicon: 0.60%
- Manganese: 1.00%
- Phosphorus: 0.021%
- Sulfur: 0.011%
- Iron: Balance

TYPICAL MECHANICAL PROPERTIES AS WELDED

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Strength</td>
<td>Up to 81,000 psi</td>
</tr>
<tr>
<td>Yield Strength</td>
<td>71,000 psi</td>
</tr>
<tr>
<td>Elongation in 2&quot;</td>
<td>30.0</td>
</tr>
</tbody>
</table>

WELDING PROPERTIES:
E7018 is an all position iron powder, low hydrogen, efficient steel electrode that yields a high deposition rate, excellent properties and x-ray quality welds. E7018 exhibits a quiet, stable, crack resistance, spatter free arc with a moderately heavy slag that is easy to remove revealing a bead with distinct ripples. This electrode is recommended for areas such as low alloy structures, piping, pressure vessels, boilers, heavy-duty equipment, ship building, general maintenance and fabrication that operate with AC or DCEP.

- Flat: Very short arc
- Vertical up: Use weaving technique, but do not use a whipping motion
- Overhead: Use slight weaving motion within the puddle
- Vertical down: Generally not recommended

- RECOMMENDED WELDING PARAMETERS:

<table>
<thead>
<tr>
<th>AMPS</th>
<th>3/32x12</th>
<th>1/8x12</th>
<th>5/32x12</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flat</td>
<td>65-85</td>
<td>90-130</td>
<td>130-180</td>
</tr>
<tr>
<td>Vertical/ Overhead</td>
<td>50-80</td>
<td>85-120</td>
<td>110-160</td>
</tr>
</tbody>
</table>

* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

SPECIFICATION COMPLIANCE: ANSI/AWS A5.1 & ASME SFA 5.1 E7018
WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer’s instructions, Material Safety Data Sheets (MSDSs), and your employer’s safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.

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