

## EASYARC® 7018-1

### TYPICAL APPLICATIONS

EASYARC® 7018-1 is a multi-purpose electrode with excellent operator appeal. It is recommended for the critical welding of C-Mn, micro alloyed, and low alloy structural steels. Typical applications include the welding of offshore platforms, ship building, pressure vessels and heavy steel structure on bridges and buildings

### TOP FEATURES

EASYARC® 7018-1 is an iron powder low-hydrogen type electrode for all-position welding of mild and high strength low alloy steels. The easily controlled arc of EASYARC® 7018-1 makes it easy to use on DC polarity. EASYARC® 7018-1 offers excellent mechanical properties and notch toughness.

### CONFORMANCE

- AWS A5.1: E7018-1
- ASME SFA-5.1

### WELDING POSITIONS



### APPROVAL

- ABS

### DIAMETERS / PACKAGING

Diameter x Length(mm x mm)	Inner box(KG)	Outer Carton(KG)
2.5*300	2.5/5	20
3.2*350	2.5/5	20
4.0*400	2.5/5	20
5.0*400	2.5/5	20

### MECHANICAL PROPERTIES

Electrode	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V-Notch, (J @ -45 °C)
Requirements AWS E7018-1	min. 400	min. 490	min. 22	min. 27
Typical Values	435	545	27	106

### CHEMICAL COMPOSITION

	C%	Mn%	Si%	S%	P%
Requirements AWS A5.1:E7018-1 [%] Max.	0.15	1.60	0.75	0.035	0.035
Typical Values	0.089	1.25	0.38	0.009	0.024

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TYPICAL OPERATING PROCEDURES

Diameter x Length (mm x mm)		2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
Current (A)	AC	80-120	100-160	140-210	200-300
Current (A)	DC±	70-110	90-160	130-210	180-300

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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