

Sureweld 7018

Sureweld 7018 is a general purpose, easy-to-use basic DC+ electrode with good mechanical properties for welding of mild steels. Sureweld 7018 is an excellent all around performer with good welder appeal, covering many applications for mild and low alloy steels.

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

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

Welding Current	AC, DC+
Diffusible Hydrogen	< 8.0 ml/100g
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
0.04	1.33	0.58	0.005	0.012

Deposition Data			
Diameter	Current	Deposition Efficiency (%)	Deposition Rate @ 90% I max
2.4 x 356.0 mm (3/32 x 14.0 in.)	70-100 A	66.3 %	0.77 kg/h (1.7 lbs/h)
3.2 x 356.0 mm (1/8 x 14.0 in.)	90-160 A	71.6 %	1.18 kg/h (2.6 lbs/h)
4.0 x 356.0 mm (5/32 x 14.0 in.)	130-220 A	75.0 %	1.41 kg/h (3.1 lbs/h)