



S. R. Industries

STAR ARC 7018

E7018 is a low-hydrogen iron powder type electrode that produces high quality x-ray welds. It can be used in all positions on AC or DC reverse polarity welding current. E7018/E7018-1 is recommended for welding medium grade carbon steels where no preheat is used, and on cold rolled steels normally exhibiting excessive porosity when welded with conventional electrodes.

Typical Applications : Low-alloy structurals, low, medium and high carbon steels, offshore rigs and power plants, steel structures, tack welds for tubular wire applications.

AWS Class : E7018/E7018-1	Classification : AWS A5.1/A5.1M:2004
Alloy : E7018	ASME SFA A5.1
Welding Position : F, V, OH, H	Current : AC-DCEP
Tensile Strength, kpsi:	70 min
Yield Strength, kpsi:	58 min
Elongation in 2" (%):	22 min

Typical Wire Chemistry as per AWS A5.1 (single values are maximum)

C	Mn	Si	P	S	Ni	Cr	Mo	V	Combined Limit for Mn+Ni+Cr+Mo+V
0.15	1.60	0.75	0.035	0.035	0.30	0.20	0.30	0.08	1.75

Typical Welding Parameters

Diameter		Process	Volt	Amps (flat)	Amps (V/OH)
in	(mm)				
3/32	(2.4)	SMAW	21-25	65-80	65-75
1/8	(3.2)	SMAW	21-25	90-110	80-95
5/32	(4.0)	SMAW	21-26	135-160	120-140
3/16	(4.8)	SMAW	22-26	160-210	140-160

Address : C-617, DSIIDC, Narela, Delhi-110040 India

Tel : 011 47506585 **Mobile :** + 91 9911166585

E.Mail : srindus@yahoo.com

Website : www.stararc.in