

Inweld 7018

AWS A5.1 E7018

Chemical Composition of Inweld 7018

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu
Balance	0.15	0.20	0.30	0.30	1.60	0.75	0.035	0.035	0.08	---

Single values are maximum unless otherwise specified.

Description and Applications

General purpose, all-position electrode for welding carbon steel, free machining steel, high tensile steel, and low alloy steel. Special low-hydrogen iron powder coating produces a quiet steady arc, low spatter and medium arc penetration. High deposition efficiency. X-ray quality weld deposits with a finely rippled smooth bead appearance and easy slag removal. Excellent charpy impact values at sub-zero temperatures (65 ft-lbs at -20°). Typical applications include tramp steels, structural and fabrication steels such as beams, angles, channels and plates, cast steels, process piping steels, cold rolled steel, and shipbuilding steels.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	70,000 psi
Yield Strength:	58,000 psi
Elongation:	22%

Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"		70-100
1/8"		115-165
5/32"		150-220
7/32"		260-340
1/4"		315-400

INWELDCORPORATION.COM

Pennsylvania
3962 Portland Street
Coplay, PA 18037

North Carolina
1029 S. Marietta St.
Gastonia, NC 28054

Texas
9300 Lawndale St.
Houston, TX 77012

California
6201 Coliseum Way, Unit A
Oakland, CA 94621