LINCOLN 7018-1

TOP FEATURES

- Excellent for general purpose welding
- Good impact values down to -46°C
- Shall be welded in AC and DC+/- mode

CLASSIFICATION

AWS A5.1	E7018-1 H4
EN ISO 2560-A	E 42 4 B 32 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.06	1.3	0.30	0.025	0.025

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
Typical values	AW	≥430	490-550	≥24	≥47

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	65-95
3.2x350	100-135
3.2x450	85-135
4.0x350	110-210
4.0x450	110-210
5.0x450	170-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	VPMD	90	2.0	619181, 629181
	CBOX	185	4.1	619036, 629036
3.2x350	VPMD	55	1.9	619182, 629182
	CBOX	120	4.2	619038, 629038
3.2x450	VPMD	55	2.5	619225, 629225
	CBOX	120	5.5	619040, 629040
4.0x350	VPMD	40	2.0	619183, 629183
	CBOX	85	4.3	619044, 629044
4.0x450	VPMD	40	2.7	619226, 629226
	CBOX	85	5.8	619045, 629045
5.0x450	CBOX	55	5.5	619049, 629049

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.