

EASYARC® 7018-1H4R

TYPICAL APPLICATIONS

EASYARC® 7018-1H4R is a multi-use electrode with excellent operator appeal. EASYARC® 7018-1H4R 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, mining machinery and heavy steel structure on bridges.

TOP FEATURES

- Superb weld profiles in all positions
- Diffusible hydrogen below 4ml/100g
- Slag removal is easy
- Excellent toughness, cracking and resistance to moisture pickup
- Manufactured under a quality system certified to ISO 9001 requirements

CONFORMANCE

· AWS A5.1/A5.1M: E7018-1H4R

WELDING POSITIONS



DIAMETERS / PACKAGING

Diameter x Length(mm x mm)	Weight /Packet (KG)	Weight / Carton (KG)	Packets per Carton	Product No.
2.5*350	2.5	20	8	CC012474
3.2*350	2.5	20	8	CC012456
4.0*400	2.5	20	8	CC012457
5.0*400	2.5	20	8	CC012458

MECHANICAL PROPERTIES

Electrode	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V-Notch, (J @ -45°C)	Diffusible Hydrogen (ml/100g)
AWS E7018-1H4R Requirement	min. 400	min. 490	min. 22	min. 27	max. 4.0
Typical Values	410	515	31.5	128	2.04

CHEMICAL COMPOSITION

	C%	Mn%	Si%	S%	P%
AWS E7018-1H4R Requirement (%) Max.	0.15	1.60	0.75	0.035	0.035
Typical Values	0.049	1.40	0.36	0.010	0.024

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TYPICAL OPERATING PROCEDURES

Diameter x Length (mm x mm)		2.5 x300	3.2 x 350	4.0 x400	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.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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Authorized Distributor:

The product performance data of this brochure and related attachments are from LINCOLN ELECTRIC application engineering laboratory. Except for special instructions, experiments on welding machines are conducted in accordance with the general standard of IEC60974-1; experiments on welding consumables are conducted in accordance with the general standard of AWS; for specific applicable standards on welding consumables please refer to the product page. The product performance data of this website and related attachments are from LINCOLN ELECTRIC American application engineering laboratory.

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