

EASYARC® 7018

TYPICAL APPLICATIONS

EASYARC® 7018 is a multi-purpose electrode with excellent operator appeal. EASYARC® 7018 is excellent for welding of mild and low alloy steel, which is used for bridges, buildings, ship building, pressure vessels, etc. EASYARC® 7018 can also be used for the construction or repair of earth moving, farm and mining equipment.

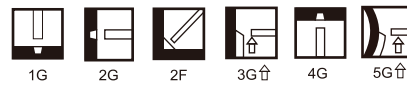
TOP FEATURES

EASYARC® 7018 is an iron powder low-hydrogen type electrode for all-position welding of mild and low alloy steels. The easily controlled arc of EASYARC® 7018 makes it easy to use on DC & AC polarity. EASYARC® 7018 offers excellent mechanical properties, high efficiency and high impact values at -30°C. It is also easy to strike and restrike

CONFORMANCE

- AWS A5.1: E7018
- ASME SFA-5.1

WELDING POSITIONS



DIAMETERS / PACKAGING

Diameter x Length(mm x mm)	Weight / Inner box / PERMAPACK Tube (KG)	Weight / Outer carton (KG)
2.6*350	2.5 / 5	20
3.2*350	2.5 / 5	20
4.0*400	2.5 / 5	20
5.0*400	2.5 / 5	20

MECHANICAL PROPERTIES

Electrode	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V-Notch, (J @ -30 °C)
AWS A5.1 E7018 Requirement	min. 400	min. 490	min. 22	min. 27
Typical Values	455	555	33	150

CHEMICAL COMPOSITION

	C%	Mn%	Si%	S%	P%
Requirements AWS A5.1:E7018(%) Max.	0.15	1.60	0.75	0.035	0.035
Typical Values	0.07	1.10	0.40	0.020	0.023

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TYPICAL OPERATING PROCEDURES

Diameter x Length (mm x mm)		2.5x300	3.2 x 350	4.0x400	5.0 x 400
Current (A)	AC	70-110	90-160	130-210	180-300
Current (A)	DC+	80-120	100-160	140-210	200-300

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.

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Authorized Distributor:

THE NANJING LINCOLN ELECTRIC CO., LTD.

No.18 Baoxiang Road, Bingjiang Economic Development Zone, Jiangning District, Nanjing, Jiangsu, China 211100

TEL:86-25-8418 8377

FAX:86-25-8641 8809

