

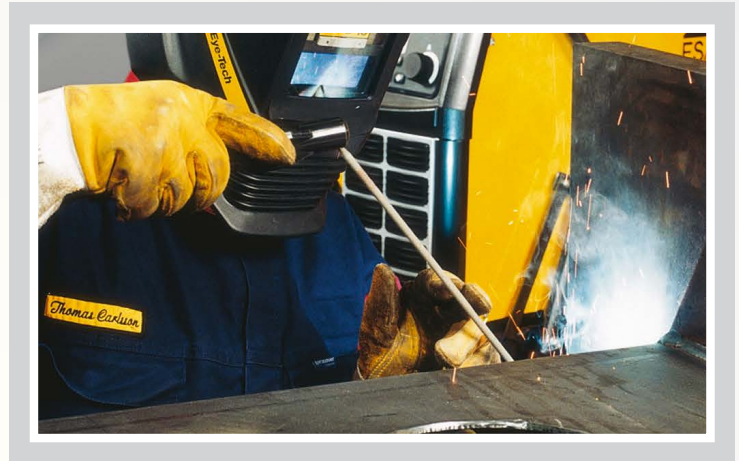
ESAB Xpert 7018 & 7018-1

Basic coated electrodes for manual metal arc welding of carbon-manganese and fine grained steels.

ESAB Xpert 7018 : AWS A5.1 E7018

ESAB Xpert 7018-1 : AWS A5.1 E7018-1

Welding Current : DC+, AC 70V



Description

ESAB Xpert 7018 & ESAB Xpert 7018-1 are basic coated, hydrogen controlled iron powder electrodes designed for welding in all positions. These electrodes provide excellent welding performance with stable arc, good arc striking & restriking properties and deposits radiographic quality welds. ESAB Xpert 7018-1 delivers good CVN impact toughness up to -46°C.

Typical Weld Metal Properties

Properties	ESAB Xpert 7018	ESAB Xpert 7018-1
C	0.08	0.08
Mn	1.20	1.25
Si	0.40	0.35
P	0.025	0.025
S	0.025	0.025
YS (MPa)	440	430
UTS (MPa)	530	530
Elongation (%)	28	28
CVN Impact (J)	70	55
Impact Temp. (°C)	-30	-46

Applications

- Structural fabrication
- General fabrication
- Pressure vessels

Features

- Good arc stability
- Radiographic quality welds
- All position welding
- Good arc striking & restriking