

7018

THIS IS A WELDING ROD WITH A LOW HYDROGEN CONTENT AND POWDER IRON COVERING. ITS RESULTING JOINTS HAVE EXCELLENT MECHANICAL PROPERTIES AND ITS FILLER METAL IS HIGH PERFORMANCE (120% APPROXIMATELY), IF COMPARED TO THE ELECTRODE METAL CORE.

CLASSIFICATION A.W.S: E-7018

IDENTIFICATION: GREY COATING

APPLICATIONS: 7018 welding rods produce optimal quality welds which are pore and crack free. Its welds successfully pass X-ray tests. This electrode can be used to weld steel containing phosphor or sulphur. It can also be used with cold rolled steel, low and medium carbon steel and low alloy steel. Since its filler metal has great ductility and resistance, Vilchis 7018 can be used to join those hard to weld materials. It is ideal for agricultural equipment parts, for dirt moving and construction equipment parts; for cranes, bridges and high pressure pipes; for hydraulic gates and for store tanks, structures, railway tanker cars and railway cars, railroad equipment, automotive equipment, electric equipment, power station equipment, shipyard equipment, etc.

CHARACTERISTICS AND PROCEDURE: This is an electrode with a low hydrogen content and powder iron covering. It is a high performance welding rod (120%). It can be used to weld with any current and in all positions. The arc is outstandingly stable and there is very little splatter. For best results, clean the joint area to remove dirt, scales, grease and rust. When welding with thicknesses over 3 mm (1/8"), edges should be chamfered at 70°. When welding with DC, connect the electrode holder to the positive pole (reverse polarity). Once the slag starts cooling down, it will peel off. Use only dry electrodes. If the welding rods were wet, they should be dried for two hours between 375° and 400°C.

TENSILE RESISTANCE:	4,925 - 5,485 KG./CM2 (70,000 A 78,000 PSI)
ELASTIC LIMIT:	4,430 - 4,925 KG./CM2 (63,000 A 70,000 PSI)
ELONGATION IN 5 cm:	32%
IMPACT TEST :	2.77 KG. X M
CHARPY V:	A (-29°C) 20 pie-lb
BRINELL HARDNESS:	180 BHN
POSITIONS:	ALL
CURRENT:	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	P	S	Si		
0.09	0.80	0.03	0.03	0.6	2.25 mm 3/32"	60-85
					3.25 mm - 1/8"	100-130
					4.0 mm - 5/32"	140-180
					5.0 mm - 3/16"	200-250