

# 7018-A1

WELDING ROD WITH 0.5% MOLYBDENUM TO BE USED WITH CARBON MOLYBDENUM STEEL IN BOILERS, PRESSURE VESSELS AND HIGH PRESSURE PIPES.

CLASSIFICATION A.W.S: E-7018-A1

IDENTIFICATION: GREY COATING

**APPLICATIONS:** It is recommended for the construction and repair of vessels and of equipment submitted to high temperatures as pipes, boilers and pressure vessels. Vilchis E-7018Al welding rod is recommended for use with the following steel A.S.T.M. ratings : A83-59 GR.A and B, A106 -58 GR. C, A212-57 GR.A and B, A216-59 GR.WCA and WCB.A250-58, A252-59 GR.3, A266-57 GR.3, A292-59 GR.1, A306-57 GR.65-70, A336-70Al GR. F1, A356-58 GR. 2, A426-59 GR..2, A426-59 GR.CP1 and CP1S and A161 T1.

**CHARACTERISTICS AND PROCEDURE:** The weld seams are smooth and are free of cavities and splatter. Its Molybdenum content provides high temperature resistance (up to 500° C). Clean the joint area to remove dirt, scales, grease and rust. Keep the arc short and always use dry electrodes. In case the welding rods were wet, they should be dried for two hours between 375° to 400° C.

<b>TENSILE RESISTANCE:</b>	5,100 - 6,100 KG./CM2 (72,256 A 87,000 PSI)
<b>ELASTIC LIMIT:</b>	4,498 - 4,850 KG./CM2 (63,990 A 69,000 PSI)
<b>ELONGATION IN 5 cm:</b>	33%
<b>IMPACT TEST:</b>	N/A.
<b>BRINELL HARDNESS:</b>	190 BHN
<b>POSITIONS:</b>	ALL
<b>CURRENT:</b>	AC or DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %						SIZES	AMPERAGE
<b>C</b>	<b>Mn</b>	<b>P</b>	<b>S</b>	<b>Si</b>	<b>Mo</b>	2.25 mm - 3/32"	60-85
0.07	1.08	0.03	0.03	0.6	0.53	3.25 mm - 1/8"	100-130
						4.0 mm - 5/32"	140-180
						5.0 mm - 3/16"	200-250