

DESCRIPTION

EXECUTIVE PLUS 7018-1 is a low-hydrogen coated electrode used extensively in all industries to weld carbon and low alloy steels. This electrode has excellent strength and toughness properties; each lot is supplied with a CMTR that reports actual chemistry and actual mechanical results (Yield, Tensile, Elongation and CVN impact tested at -58°F / -50°C).

This electrode provides a smooth, stable arc that produces little or no spatter and provides excellent arc starting and re-strike capabilities with an easy to remove slag covering.

Recommended for welding structural steel, general construction, pressure vessels, boilers, pipes, bridges, power plants, marine industry and wherever high quality welds are required.

E7018 CLASSIFICATION AND DESIGNATORS

EXECUTIVE 7018-1 PLUS is classified by AWS as an E7018-1 H4R coated electrode. To better understand that nomenclature: **E** - stick electrode; **70** - 70,000 psi tensile strength; **1** - all welding positions; **8** - indicates low-hydrogen coating.

Additional designators: **H4** indicates 4 ml or less of diffusible hydrogen per 100 g of weldment; **R** indicates this product has undergone testing to be moisture-resistant; **-1** electrodes offer impact values of 20 ft-lb at -50°F compared to a standard E7018 with impact values of 20 ft-lb at -20°F.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES AS WELDED

C	Si	Mn	P	S	Cr	Mo	Ni	V	Cu
0.08	0.50	1.20	0.015	0.015	0.01	0.02	0.01	0.01	0.02

Tensile Strength:	81,200 PSI min	Yield Strength:	71,100 PSI min	Elongation:	30%
Charpy V-Notch:	70 ft/lb at at -58°F / -50°C				

TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage	Approx Pieces
SMAW AC/DC	3/32"	12"	80-110	204
	1/8"	14"	100-140	128
	5/32"	18"	130-180	89
	3/16"	18"	180-230	44
	1/4"	18"	230-290	20

STANDARD PACKAGING & HANDLING

All diameters of Executive PLUS E7018-1 are in 10-lb hermetically sealed (HSC) cans with protective packaging in a 30-lb master box.

EX70181P0000930E0000	10-lb HSC	30-lb master box	1,500-lb pallet
EX70181P0001250E0000	10-lb HSC	30-lb master box	1,500-lb pallet
EX70181P0001560E0000	10-lb HSC	30-lb master box	1,080-lb pallet
EX70181P0001870E0000	10-lb HSC	30-lb master box	1,080-lb pallet
EX70181P0002500E0000	10-lb HSC	30-lb master box	1,080-lb pallet

CLASSIFICATION & APPROVALS

AWS A5.1/ASME SFA 5.1, Class **E7018-1 H4R**

Approvals: CWB, ABS (Grade 3YH5), DNV-GL, LR

Material certificates to EN 10204 3.1 (for chemical analysis and mechanical properties)

EN ISO 2560-A

