

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 and 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 -58°F / -50°C								
Post Weld Heat-Treat (620°C for 2 hours)										
Tensile Strength:		76,800 PSI min		Yield Strength:		62,300 PSI min		Elongation:		35%
Charpy V-Notch:		90 ft/lb at -58°F / -50°C								

TYPICAL WELDING PARAMETERS

Process	Diameter	Length	Amperage	Approx Pieces
SMAW	3/32"	12"	80-110	204
AC/DC	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 cans (HSC) with protective packaging in a 30-lb master box.

3/32"	EX70181P0000930E0000	1,500-lb pallet	5/32"	EX70181P0001560E0000	1,080-lb pallet
1/8"	EX70181P0001250E0000	1,500-lb pallet	3/16"	EX70181P0001870E0000	1,080-lb pallet
			1/4"	EX70181P0002500E0000	1,080-lb pallet

CLASSIFICATION & APPROVALS

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

EN ISO 2560-A

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

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

