

Special Feature, Low-Hydrogen Electrode For Crack-Resistant Welds

EutecTrode® 7018RS



WELDING

- Meets AWS A5.1 specifications
- All-position, easy to use and Welder-friendly
- Best choice for highly hardenable and HSLA steels



DESCRIPTION:

EutecTrode 7018RS is an all-position, low-hydrogen electrode designed for the welding of steels susceptible to certain forms of underbead and embrittlement cracking. Also suitable for general fabrication and repair of most low-alloy and carbon steels.

TYPICAL APPLICATIONS:

Can be used on a wide variety of plain carbon and low-alloy steels. Such steel grades are typically encountered in the Mining, Construction, and Civil Engineering Industries. Applications would be heavy-duty equipment frames, chassis, truck bodies, ore cars, general fabrications.

TECHNICAL DATA:

Typical Tensile Strength: 76,000 psi (524 N/mm²)

Typical Yield Strength: 65,000 psi (448 N/mm²)

Typical Elongation in 2 in. min: 22%

Current & Polarity: DCEP (+) and AC

Availability and Recommended Amperages

Diameter	Amperage
3/32" (2.4mm)	65-80
1/8" (3.2mm)	120-135
5/32" (4.0mm)	165-175
3/16" (4.8mm)	215-235

WELDING PARAMETERS:

Preparation: Clean weld area of scale and/or oxide. Bevel or chamfer heavy sections to have either a single or double 60° "V" prep. A nominal preheat of 150°F is advised if part is below 40°F or over 1" thick. For higher carbon steels higher preheats will be needed.

Technique: All low-hydrogen electrodes should be used with a non-contact, short arc gap technique. An arc start-block is recommended to prevent starting porosity. Deposit stringer beads or 2 times to 3 times weave beads.

Note: Always keep electrodes in an appropriate dry storage container or rod oven once opened to prevent excess moisture absorption. Inappropriately stored electrodes can cause cracking and porosity in the weld. For additional information on exposure time, redrying and storage contact Technical Services.

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