Castolin Eutectic
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Premium, Low Hydrogen, Moisture Resistant Electrode

EutecTrode® 7018RS

- Compliance to AWS A5.1 E7018
- All-position, easy to use and welder-friendly
- Ideal for critical applications
- Features a Rapid Strike igniter tip for easy arc starting

EutecTrode® 7018RS

EutecTrode E7018RS is an all-position, low-hydrogen electrode designed for the welding of steels susceptable to certain forms of underbead and embrittlement cracking. Also suitable for general fabrication and repair of most low-alloy and carbon steels. Deposits have good ductility, are dense, crack-free and of x-ray quality.

TECHNICAL DATA

Typical Values	
Tensile Strength:	76,000 psi (524 N/mm²)
Yield Strength:	68,000 psi (470 N/mm²)
Elongation (1=5d) min.:	31%
Typical Reduction in Area:	75%
Typical V-Notch Impact:	70 ft lbs @ -50°F
Current & Polarity:	DCEP (+) or AC (~)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	60-100	110-150	140-220

PROCEDURE FOR USE

PREPARATION: Clean weld area of scale and/or oxide. Bevel or chamfer heavy sections to have either a single or double 60º "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 2x to 3x weave beads.

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

TYPICAL APPLICATIONS

EutecTrode 7018RS 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 and general fabrication with H and I beams.