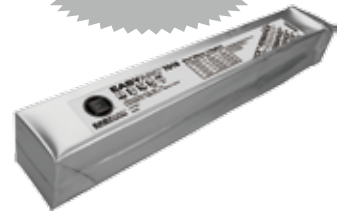


MILD STEEL STICK ELECTRODE

# EASYARC™ 7018

PERMAPACK™



EASYARC™ 7018 is an iron powder low-hydrogen type electrode for all-position welding of mild and low alloy steels. The easily controlled arc of EASYARC™ 7018 makes it easy to use on DC & AC polarity. EASYARC™ 7018 offers excellent mechanical properties, high efficiency and high impact values at -30°C. It is also easy to strike and restrike.

## CONFORMANCE

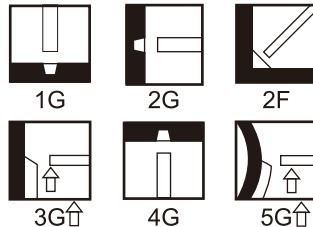
AWS A5.1: E7018

ASME SFA-5.1

## ADVANTAGE LINCOLN

- High deposition rates
- Easy slag removal
- Excellent crack resistance and X-ray performance
- Flat or slightly convex beads have distinct ripples with little spatter
- Manufactured under a quality system certified to ISO 9001 requirements
- Available in PERMAPACK™<sup>(1)</sup> (Vacuum Sealed)

## WELDING POSITIONS



## APPROVALS

ABS: 3YH10

LR: 3YH15

## APPLICATION

EASYARC™ 7018 is a multi-purpose electrode with excellent operator appeal. EASYARC™ 7018 is excellent for welding of mild and low alloy steel, which is used for bridges, buildings, ship building, pressure vessels, etc. EASYARC™ 7018 can also be used for the construction or repair of earth moving, farm and mining equipment.

## GUIDELINES FOR USE

- All water, rust and oil should be completely removed from base material to prevent cracking and blowholes.

- Backstep method should be applied to prevent blowholes and pits during starting. Arc length should be kept as short as possible during welding.
- If weaving is required, the width should not exceed 3x the diameter of the electrode.

## REDRYING

All controlled hydrogen electrodes will perform optimally when they are dry. Unopened Lincoln PERMAPACK's provide excellent protection against moisture pick-up in good storage conditions. Should re-drying be necessary, remove electrodes from the packet / container and spread thinly and evenly on racks in a ventilated oven. For electrodes that have had a short or mild exposure to the atmosphere then re-drying at 572°F(300°C) for 1 hour will be sufficient. For electrodes that have been exposed to longer or more aggressive conditions or for critical work re-drying at 572-662°F (300-350°C) for 1-2 hours is recommended. After re-drying electrodes should be stored in a hot box.

## DIAMETERS / PACKAGING

	Diameter × Length (mm)	Weight (kg)		Packet per Carton	Product No.
		Packet	Carton		
PERMAPACK™ <sup>(1)</sup> Tube	2.5 × 300	2.5	20	8	CC010405
	3.2 × 350	2.5	20	8	CC010406
	4.0 × 400	2.5	20	8	CC010407
	5.0 × 400	2.5	20	8	CC010408
	Diameter × Length (mm)	Weight (kg)		Packet per Carton	Product No.
		Packet	Carton		
Standard Packaging	2.5 × 300	5	20	4	CC010401
	3.2 × 350	5	20	4	CC010402
	4.0 × 400	5	20	4	CC010403
	5.0 × 400	5	20	4	CC010404

(1) The electrodes are placed in a plastic box, and then are vacuum-packed in moisture proof, foil-poly bags to prevent moisture pick-up.

**MECHANICAL PROPERTIES, ALL WELD METAL**

	Yield Strength Mpa	Tensile Strength Mpa	Elongation (%)	Impact ISO -V, J@-30°C
<b>Required AWS E7018</b>	min.400	min.490	22	min.27
<b>Typical Values</b>	455	555	33	150

**CHEMICAL COMPOSITION, ALL WELD METAL**

	C	Mn	Si	S	P
<b>Requirements AWS E7018 (%) Max.</b>	0.15	1.60	0.75	0.035	0.035
<b>Typical Results(%)</b>	0.07	1.10	0.40	0.020	0.023

**RECOMMENDED WELDING CURRENT(DC+, AC)**

Diameter x Length (mm)		2.5 x 300	3.2 x 350	4.0 x 400	5.0 x 400
<b>Current (A)</b>	<b>DC+</b>	70-110	90-160	130-210	180-300
	<b>AC</b>	80-120	100-160	140-210	200-300

**Customer Assistance Policy**

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn) for any updated information.



**THE NANJING  
LINCOLN ELECTRIC  
Co., LTD**

No.2, Qiande Road, Jiangning  
Science Park, Jiangning District,  
Nanjing, Jiangsu, China 211100  
TEL: +86-25-8645 2736 8418 8377  
FAX: +86-25-8641 8809  
[www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn)

Publication CC1.007.EN Stick Rod  
11/09

**Authorized Distributor:**