

# EASYARC™ 7018-1H4R



EASYARC™ 7018-1H4R is an iron powder low-hydrogen type electrode for all-position welding of mild and low alloy steels. The strictly controlled diffusible hydrogen and moisture of EASYARC™ 7018-1H4R makes it well suited for critical welding applications that require excellent cracking resistance. EASYARC™ 7018-1H4R offers superb mechanical properties, notch toughness and high efficiency at low temperature.

## APPLICATION

EASYARC™ 7018-1H4R is a multi-use electrode with excellent operator appeal. EASYARC™ 7018-1H4R is recommended for the critical welding of C-Mn, micro alloyed and low alloy structural steels. Typical applications include the welding of offshore platforms, ship building, pressure vessels, mining machinery and heavy steel structure on bridges.

## CONFORMANCE

AWS A5.1/A5.1M: E7018-1H4R

## LINCOLN ADVANTAGE

- Superb weld profiles in all positions
- Diffusible hydrogen below 4ml/100g
- Slag removal is easy
- Excellent toughness, cracking and resistance to moisture pickup
- Manufactured under a quality system certified to ISO 9001 requirements

## WELDING POSITIONS



## PACKING

The electrodes are in a plastic box and then vacuum-sealed in moisture proof, polyfoil bags to prevent moisture pick-up. 8 vacuum sealed packages are then stored inside a master carton. For large shipments, the cartons are securely stacked on wooden pallets and covered with plastic shrink-wrap.

**EASYARC™ 7018-1H4R****DIAMETERS / PACKAGING**

Diameter × Length (mm × mm)	Weight (kg)		Packets per Carton	Product No.
	Packet	Carton		
2.5 x 350	2.5	20	8	CC012473
3.2 x 350	2.5	20	8	CC012456
4.0 x 400	2.5	20	8	CC012457
5.0 x 400	2.5	20	8	CC012458

**MECHANICAL PROPERTIES, ALL WELD METAL**

	Yield Strength Mpa	Tensile Strength Mpa	Elongation (%)	Impact ISO -V @-45°C (J)	Diffusible Hydrogen (ml/100g)
<b>AWS E7018-1H4R Requirement</b>	Min.400	Min.490	Min.22	Min.27	Max.4.0
<b>Typical Values</b>	410	515	31.5	128	2.04

**CHEMICAL COMPOSITION, ALL WELD METAL**

	C	Si	Mn	S	P
<b>AWS E7018-1H4R Requirement (%) Max.</b>	0.15	0.75	1.60	0.035	0.035
<b>Typical Values (%)</b>	0.049	0.36	1.40	0.010	0.024

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

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

**Customer Assistance Policy**

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**Authorized Distributor:****THE NANJING LINCOLN ELECTRIC Co., LTD**

No.2 Qiande Road, Jiangning Science Park, Nanjing, Jiangsu Province, China 211100  
Tel: +86-25-8645-2736 8418-8377 Fax: +86-25-8641-8809

[www.lincolnelectric.com.cn](http://www.lincolnelectric.com.cn)

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