Inweld 7018AC

AWS A5.1 E7018AC

Chemical Composition of Inweld 7018AC

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu
Balance	0.20	0.20	0.30	0.30	1.60	0.75	0.035	0.035	0.08	---

Description and Applications

General purpose AC electrode for all-position welding of low, medium, and high carbon steel, free machining steel, high tensile steel, and some low alloy steels. Excellent arc stability with medium penetration using small AC welding machines. Graphite tip allows for quick arc ignition and the unique flux-coating permits easy arc restrike or regeneration of the arc over and over again. Commonly used for tack welding. Weld deposits have a nice smooth ripple and slag removal is easy. Typical applications include "tramp" steels, structural and fabrication steels, such as I-beams, angles, channels and plates, cast steels, cold rolled steels, and ship building steels. Commonly used in farm and shop applications.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	79,000 psi
Yield Strength:	58,000 psi
Elongation:	22%

Recommended Parameters

SMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage
3/32"		70-115
1/8"		100-140
5/32"		120-185