Inweld 7018 H4R

AWS A5.1 E7018 H4R

Chemical Composition of Inweld 7018 H4R

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu
Balance	0.15	0.20	0.30	0.30	1.60	0.75	0.035	0.035	0.08	---

Single values are maximum unless otherwise specified.

Description and Applications

E7018 H4R is a moisture resistant, hydrogen controlled, vacuum packed, premium coated electrode which is

welder friendly and is recommended for welding of mild and medium carbon steel, high strength steel, cast steel and problematic steels. The weld metal is clean and has lowest level of impurities thus having unique properties of resistance to ageing.

All maintenance applications including welding of all types of carbon-manganese steels, high tensile, heavy structures, plants and subject to static or dynamic loading. Can be used as a buffer layer before hard facing.

Moisture resistant

The electrode has a low-moisture-absorbing coating. Additionally each tube is vacuum packed. This minimizes the need for drying. If redrying is required, proceed at 250°C for 2 hours or a higher temperature.

Diffusible Hydrogen

< 4ml / 100gm weld metal

Typical Weld Metal Properties

Tensile Strength N/MM2: 550-640
Yield Strength N/MM2: ≥450
Elongation A5%: ≥28

Recommended Parameters

SMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage
3/32”		70-100
1/8”		100-140
5/32”		140-190
3/16”		190-240

POLARITY: DCEP or AC 70V

DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration

AC: medium weld penetration (can be more spatter)

WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions

USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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