Inweld 7018R

AWS A5.1 E7018 H4R

NEW PRODUCT

Inweld Welding Alloys & Supplies

Chemical Composition

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	—

Maximum values unless otherwise specified.

Features

- Premium moisture resistant coating
- Excellent restrike without porosity
- Reduced moisture pickup vs. Inweld 7018
- Superior rip proof mylar vacuum packaging

Applications

- Pressure vessels and piping
- Structural and shipbuilding
- Mild and medium carbon steel
- High strength steel
- Buffer layer before hard facing

Diffusible Hydrogen
< 4ml / 100gm of weld metal

Typical Weld Metal Properties	
Tensile Strength MPa (ksi)	550-640 (79-93)
Yield Strength MPa (ksi)	≥450 (65)
Elongation %:	≥28

POLARITY:	DCEP or AC
DCEP:	DC, Electrode Positive (reverse polarity) has the most weld penetration
AC:	Medium weld penetration
WELDING POSITIONS:	Flat, Horizontal, Overhead and Vertical-up

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

Recommended Parameters

SMAW (DCEP – Electrode+)

Wire Diameter	Amperage
3/32" (2.4mm)	70-100
1/8" (3.2mm)	100-140
5/32" (4.0mm)	140-190
3/16" (4.8mm)	190-240



Part Number	Description
WE7018R093	7018 3/32 x 10lb Electrode E7018 H4R Vacuum Sealed
WE7018R125	7018 1/8 x 10lb Electrode E7018 H4R Vacuum Sealed
WE7018R156	7018 5/32 x 10lb Electrode E7018 H4R Vacuum Sealed
WE7018R187	7018 3/16 x 10lb Electrode E7018 H4R Vacuum Sealed

Pennsylvania
3962 Portland Street
Coplay, PA 18037

inweldcorporation.com
Phone: 800.346.5368
Fax: 877.346.5368

© Inweld Corporation

Texas
9300 Lawndale St.
Houston, TX 77012