



Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925

# 7018-1 Carbon Steel Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



## ALLOY DESCRIPTION AND APPLICATION;

7018-1 is general low hydrogen mild steel all position electrodes recommended for mild – high carbon base metals, shipbuilding/barge offshore drilling rigs power, petrochemical and boiler plants. These rods are formulated to have quality welds with very easy slag removal or self-peeling, excellent welder appeal on those poor weldable steels. 7018-1 is easy to control which is used often for high impact level at -50°F while providing a stable arc with a flat to slightly convex fine ripple weld appearance.

## TYPICAL WELDING PROCEDURES; DCEP, AC

Diameter	Amps (Flat)	Volts
3/32"	70-120	19-23
1/8"	90-160	23-27
5/32"	130-210	25-31

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

## TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	Weld Metal		AWS Spec.	Weld Metal
Carbon	0.15	0.02	Chromium	0.20	0.01
Manganese	1.60	1.05	Molybdenum	0.30	0.01
Silicon	0.75	0.49	Vanadium	0.08	<0.01
Phosphorus	0.035	0.010	Elongation in 2" (%)	22%	28%
Sulphur	0.035	0.014	Yield Strength (ksi)	58	67
Nickel	0.30	0.065	Tensile Strength (ksi)	70	79
Mn + Ni + Cr + Mo + V	1.50	Charpy V-notch -50°F		20 ft·lbs min	73
		-20°F		20 ft·lbs min	95

**AVAILABLE SIZES:** TE 7018-1 = 3/32", 1/8", 5/32"

**SPECIFICATIONS;** ANSI/AWS A5.1 E7018-1, E7018

ASME SFA 5.1 E7018-1, E7018



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