



Sureweld 7018

Sureweld 7018 is a general purpose, easy-to-use basic DC+ electrode with good mechanical properties for welding of mild steels. Sureweld 7018 is an excellent all around performer with good welder appeal, covering many applications for mild and low alloy steels.

Classifications	AWS A5.1 : E7018 ASME SFA 5.1
Approvals	ABS
Industry	Automotive Bridge Construction Civil Construction Industrial and General Fabrication Mobile Equipment Railcars Ship/Barge Building

Welding Current	AC or DC+
Coating Type	Low-hydrogen iron powder
CTOD-Tested	false

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	538 MPa (78 ksi)	607 MPa (88 ksi)	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-29 °C (-20 °F)	145 J (107 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.04	1.33	0.58	0.005	0.012

Deposition Data

Diameter	Current	Deposition Rate	Deposition Efficiency (%)	Optimal Amps
4.0 mm (5/32 in.)	130-220 A	1.1 kg/h (3.1 lbs/h)	75 %	140 A
3.2 mm (1/8 in.)	90-160 A	1.2 kg/h (2.6 lbs/h)	71.6 %	120 A
2.4 mm (3/32 in.)	70-100 A	0.8 kg/h (1.7 lbs/h)	66.3 %	90 A