

Excalibur® 7018-1MR

Key Features

- Premium arc performance
- Moisture resistant basic coating
- Q2 Lot certified showing chemistry and mechanical properties available online
- Easy strike and restrike, square coating burn-off

Conformances

AWS A5.1/A5.1M: E7018-1 H4R

Lloyds Register: 3YM H5

ABS: 3YH5

Typical Applications

- Suitable for many mild and low alloy steels
- Used for general construction welding applications such as bridges, buildings and pressure vessels
- Low hydrogen electrode for critical applications

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.4	350	ED028700	Easy Open Can 22.7 kg
2.4	350	ED032591	Easy Open Can 4.54 kg (3 X EOC per Carton)
3.2	350	ED028702	Easy Open Can 22.7 kg
3.2	350	ED032592	Easy Open Can 4.54 kg (3 X EOC per Carton)
4.0	350	ED028704	Easy Open Can 22.7 kg
4.8	350	ED028706	Easy Open Can 22.7 kg

Mechanical Properties - As required per AWS A5.1 & AS/NZS 4855-B

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -45°C
Requirements - AWS	400 min	490 min	22 min	27
Requirements - AS/NZS	400 min	490 min	20 min	27
Typical Results - As Welded	460	565	28	138

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.06	1.30	0.36	0.012	0.005
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	0.02	0.03	0.25	<0.01	2-3 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)			
	2.4mm	3.2mm	4.0mm	4.8mm
DC+	70-110	90-160	130-210	180-300