

The Lincoln Electric Company
 22801 St. Clair Avenue
 Cleveland, Ohio 44117-1199



TEST RESULTS FOR INFORMATION ONLY

Product: **Excalibur® 7018 XMR™**
 Diameter: **1/8"**
 Classification: **E7018 HAR**
 Specification: **AWS A5.1:2012, ASME SFA-5.1**
 Date: **July 23, 2020**

Results for Excalibur® 7018 XMR™ – After 24 Hour Humidification

Moisture ^{1,2,3,4}

	E7018 HAR Requirements	RESULTS
Coating Moisture – As Received	0.3 max	0.1, 0.1, 0.1, 0.1, 0.1, 0.1
Coating Moisture – Humidified	N.S.	0.2, 0.3, 0.2, 0.3, 0.3, 0.2

Diffusible Hydrogen^{1,2,3,4}

	E7018 HAR Requirements	RESULTS
Current Type/Polarity		DC+
Nominal Voltage, V		22-23
Nominal Amperage, A		133
Diffusible Hydrogen, mL/100g		3, 4, 3, 3, 3, 3
Abs. Humidity (gr moisture/lb dry air)	N.S.	34-46

Notes:

1. AWS A5.1 requires 9 hours of humidification exposure. This testing was conducted with **24 hours** of humidification. Apart from exposure time, all testing was conducted in accordance with AWS A5.1.
2. N.S. indicates that AWS does not have a classification requirement for this exposure time.
3. Nominal humidification conditions were 80°F, 80% relative humidity for 24 hours.
4. Six samples were tested.

 7/23/2020 Date
 Dan Gadul, Certification Supervisor
 7/23/2020 Date
 Jonathan S Odorn, Manager, Consumable Compliance