

EASYARC® 528 MR®

Mild Steel, Low Hydrogen ▪ AWS E7018-1 H4R



KEY FEATURES

- Quality x-ray requirements
- Soft and quiet arc
- Flatter bead
- Low spatter

TYPICAL APPLICATIONS

- Power generation
- Petrochemical
- Pressure vessels
- Pressure piping
- Fill and cap pass welding of up to X65 grade pipe

CONFORMANCES

AWS A5.1:	E7018-1 H4R
ASME SFA-A5.1:	E7018-1 H4R
CWB/CSA W48-06: EN	E4918-1-H4R

WELDING POSITIONS

All, except vertical down

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Easy Open Can 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Easy Open Can 30 lb (13.6 kg) Master Carton
3/32 (2.4)	12 (300)	ED038113	
1/8 (3.2)	14 (350)		ED038114
5/32 (4.0)	14 (350)		ED038115
3/16 (4.8)	14 (350)		ED038116

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.1

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) @ -46°C (-50°F)
Requirements – AWS E7018-1 H4R	400 (58) min	490 (70) min	22 min	27 (20) min
Typical Results ⁽³⁾ – As-Welded	470-510 (69-74)	580-600 (82-87)	28 min	75 min

DEPOSIT COMPOSITION⁽¹⁾ – As Required per AWS A5.1

	%C	%Mn	%Si	%P	%S	%Ni
Requirements – AWS E7018-1 H4R	0.15 max	1.60 max	0.75 max	0.035 max	0.035 max	0.30 max
Typical Results ⁽³⁾	0.04-0.05	1.21-1.34	0.38-0.50	0.014-0.016	0.006-0.007	0.02-0.03
	%Cr	%Mo	%V	%Mn + Ni + Cr + Mo + V	Diffusible Hydrogen (mL/100g weld metal)	
Requirements – AWS E7018-1 H4R	0.20 max	0.30 max	0.08 max	1.75 max	4.0 max	
Typical Results ⁽³⁾	0.04	0.26-0.27	0.01	1.54-1.69	3-4	

TYPICAL OPERATING PROCEDURES

Polarity ⁽⁴⁾	Current (Amps)			
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)
DC+	70-110	90-160	130-210	180-300
AC	80-120	100-160	140-210	200-300

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer ⁽⁴⁾Preferred polarity is listed first.