

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



**TEST RESULTS FOR INFORMATION ONLY**

Product: **Excalibur® 7018 XMR™**  
 Diameter: **3/32"**  
 Classification: **E7018 H4R**  
 Specification: **AWS A5.1:2012, ASME SFA-5.1**  
 Date: **July 23, 2020**

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

**Moisture <sup>1,2,3,4</sup>**


	<b>E7018 H4R Requirements</b>	<b>RESULTS</b>
Coating Moisture – As Received	0.3 max	0.1, 0.1, 0.1, 0.1, 0.1
Coating Moisture – Humidified	N.S.	0.2, 0.3, 0.3, 0.3, 0.2, 0.3


**Diffusible Hydrogen <sup>1,2,3,4</sup>**

	<b>E7018 H4R Requirements</b>	<b>RESULTS</b>
Current Type/Polarity		DC+
Nominal Voltage, V		22-23V
Nominal Amperage, A		95A
Diffusible Hydrogen, mL/100g		2, 2, 2, 2, 2, 2
Abs. Humidity (gr moisture/lb dry air)	N.S.	38-74

**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.

  
 Dan Gajul, Certification Supervisor      Date 7/23/2020

  
 Jon Ogborn, Manager, Consumable Compliance      Date 7/23/2020