

# LINCOLN 7018-1

## TOP FEATURES

- Excellent for general purpose welding.
- Good impact values down to -46°C.
- Shall be welded in AC and DC+/- mode.

## CLASSIFICATION

AWS A5.1 E7018-1 H4  
EN ISO 2560-A E 42 5 B 42 H5

## CURRENT TYPE

AC/DC(+/-)

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

ABS	LR	BV	TÜV
+	+	+	+

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.06	1.3	0.30	0.025	0.025

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
Typical values	AW	≥430	490-550	≥24	≥47

AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 350	100-135
3.2 x 450	85-135
4.0 x 350	110-210
4.0 x 450	110-210
5.0 x 450	170-240

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	90	2.0	619181
	CBOX	185	4.1	619036
3.2 x 350	VPMD	55	1.9	619182
	CBOX	120	4.2	619038
3.2 x 450	CBOX	120	5.5	619040
4.0 x 350	VPMD	40	2.0	619183
	CBOX	85	4.3	619044
4.0 x 450	CBOX	85	5.8	619045

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.  
Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.