

MG E7018-1

**Superior all-position electrode
for problem steels**



GENERAL CHARACTERISTICS:

MG E7018-1 is a high strength electrode with exceptional impact characteristics at low temperatures. This high quality, all position, low hydrogen electrode features rapid deposition. Deposits have good ductility, are dense, crack-free, and of x-ray quality. MG E7018-1 is excellent for steels sensitive to cracking when welded with conventional mild steel electrodes.

APPLICATIONS:

For fabrication of "H" and "I" beams, angle and channel iron, pipelines, and all other steel structures. For circular tube to plate welds, and other type joints subject to stress and strain. Excellent for applications where low temperature charpy V-notch impacts are required.

TECHNICAL DATA:

Tensile Strength	Up to 80,000 psi (552 N/mm ²)
Yield Strength	Up to 71,000 psi (489 N/mm ²)
Charpy V-notch Impacts	Up to 70 ft-lb at -50 ⁰ F
Current	AC or DC reverse polarity (electrode +)

Diameter	Amperage
3/32" (2.4mm)	60-100
1/8" (3.2mm)	110-150
5/32" (4.0mm)	140-220
3/16" (5.0mm)	220-280

PROCEDURE:

Area to be welded should be cleaned thoroughly. Surface contamination must be removed and bevel or chamfer where required. Maintain close arc length. Vertical joints should be welded from bottom up, using rapid weave technique. Do not whip. Use drag technique to make horizontal fillet welds. Slag is easily removed.

