



XTR 7018 H4R

A5.1 E7018 -1 H4 R

Features & Applications:

For joining repairing boiler plate, pipe steels, shipbuilding steels and cast steels. Excellent for weathering steels, such as "Corten". Extra low hydrogen – Moisture resistant steel electrode for unalloyed construction steels.

- Extremely smooth - spatter and turbulence free arc transfer
- Coating is totally non-conductive
- Unusually good AC welding characteristics
- Easy re-strike

Microstructure:

In the stress-relieved condition, the microstructure consists of acicular ferrite with some tempered bainite.

Chemistry:

	Typical	AWS Spec. Single values are max.
Carbon (C)	0.040	0.150
Manganese (Mn)	1.100	1.600
Silicon (Si)	0.600	0.750
Phosphorus (P)	0.018	0.035
Combined (Mn+Ni+Cr+Mo+V)	1.200	1.750



Mechanical Properties: (All weld metal analysis, Typical Weight %)

	Typical	AWS Spec. Single values are min.
Tensile Strength	85,500	70,000 psi
Yield Strength	72,500	58,000 psi
Elongation in 2" (%)	23	22
Charpy V-Notch	>90J: -20°C	15 ft.-lbs. @ -50°F
Diffusible Hydrogen (mL/100g weld metal)	3	4 max

Coating Low Hydrogen Potassium, Iron Powder
Flux Coating, Color Tan/Grey

Welding Positions:

F, V, OH, H

Operating Parameters: Coated Electrode/Rod (SMAW), DC Reverse (+) or AC

Formula: 1033					
Procedures & results may vary with any change in position, equipment being used, base metal and base metal cleanliness.					
Diameter	Amperage Range	Weldmetal Electrode	Electrodes per lb. (kg) of Weldmetal	Arc Time of Deposition min/lb. (kg)	Electrodes (Rods) per Lb. Packaged
1/16 (1.6mm)	nr				
3/32 (2.4mm)	65-100	.42oz (12g)	38 (83)	38 (84)	21
1/8 (3.2mm)	100-140	.59oz (17g)	27 (60)	21 (47)	12
5/32 (4.0mm)	140-190	1.1oz (30g)	15 (32)	18 (39)	8
3/16 (4.8mm)	190-250	1.8oz (50g)	9 (20)	13 (28)	6
1/4 (6.4mm)	nr	--	--	--	--



SCAN for SDS

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Ver. 1.12.2023