



# EAGLE 7018 - 1

*All Position Low Hydrogen Iron Powered Electrode*

**CONFORMS TO AWS A5.1 ASME SFA 5.1**

**CLASS: 7018 - 1**

**CERTIFIED BY CWB CLASSIFICATION - E 48018-1 CSA W 48 - 06**

## **APPLICATIONS**

For welding of a variety of carbon and low alloy steels in the 50 Ksi (345 MPA) minimum yield. It is an excellent electrode for applications that require tough impact hardness at low temperatures.

## **PROCEDURE**

Use DC Reverse [+]  
Polarity. Clean weld areas with a grinder and groove out the cracks using the **EAGLE 188**.

Vertical welds should be welded from bottom up using the stringer bead technique for maximum strength. A medium arc length should be maintained while welding.

## **GENERAL CHARACTERISTICS**

The **EAGLE 7018-1** is an all position welding electrode that produces exceptional good impact results at low temperatures in both welded and stress relieved conditions.

## **TECHNICAL DATA**

Tip Colour: Mid Blue  
Tensile Strength: Approx. 80,000 - 84,000 psi  
Yield Strength: Approx. 70,000 - 72,000 psi  
Elongation: Approx. 30%

## **WELDING PARAMETERS**

Current:	DC Reverse [+] Polarity					
Sizes: Inches	3/32	1/8	5/32	3/16	1/4	
mm	2.50	3.25	4.00	5.00	6.00	
Amperage:	60-100	110-150	150-190	210-280	300-400	



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