



Unibraze 7018AC (E7018 H4)

DESCRIPTION:

Highly recommended for applications using small 208/230V, single phase AC welders, UNIBRAZE 7018AC has good operator appeal, excellent re-striking characteristics and an extremely stable arc. UNIBRAZE 7018AC is also an excellent choice for skip or tack welds. The slag is self-removing in most applications. UNIBRAZE 7018AC will work well on all AC power sources and performs exceptionally well on utility-type welders.

APPLICATIONS:

- low-, medium- and high-carbon steels
- skip or tack welds
- shops, farms, hobbyist
- some high-strength low alloy steels

TYPICAL WELD METAL PROPERTIES (Chem Pad):

Carbon	0.04
Manganese	0.07
Silicon	0.29
Chromium	0.07
Molybdenum	0.01
Nickel	0.08
Vanadium	0.02
Phosphorus	0.08
Sulphur	0.01

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength (psi)	81,200 (560 MPa)
Yield Strength (psi)	73,100 (504 MPa)
Elongation % in 2"	29.5%

TYPICAL CHARPY-V-NOTCH IMPACT VALUES:

Avg. at -20°F (-29°C) 57 ft.lb. (77J)

RECOMMENDED OPERATING RANGES:

3/32" (2.4 mm)	70-110 amps
1/8" (3.2 mm)	90-165 amps
5/32" (4.0 mm)	125-220 amps

TYPE OF CURRENT: DCEP, DCEN or AC

CONFORMANCES AND APPROVALS:

- AWS A5.1, E7018 H4
- ASME SFA 5.1, F-4, A-1, E7018

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its product.