



Unibraze 7018

CLASSIFICATIONS: AWS A5.1 E7018

DESCRIPTION: Unibraze 7018 is a low hydrogen, iron powder coated electrode used for welding 70,000 psi high tensile steels. Applications include, ships, bridges, storage tanks, building and industrial machinery. It has excellent mechanical properties and radiographic soundness as well as good bead appearance and slag removal. Redry at 500-750°F for 1-2 hours before use.

TYPICAL CHEMISTRY (All Weld Metal)

C	SI	Mn*	P	S	Ni*	Cr*	Mo*	V*	*Total
.07	.61	.87	.015	.011	.02	.03	.01	.01	.94

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	82,670 psi (570 MPa)
Yield Strength	70,000 psi (483 MPa)
Elongation	30%
Average CVN Impacts	20 ft•lbf at -20°F [27 J at -30°C]

RECOMMENDED CURRENTS (AC or DC+)

Diameter	3/32"	1/8"	5/32"	3/16"
Flat	60-100	90-130	130-180	200-250
V-OH	50-80	80-120	110-170	160-210

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 products.