DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM7018 H4R Premium Electrode

Classification: **E7018 H4R**

AWS A 5.1 / ASME SFA 5.1

DuraMax DM7018 H4R is a HYDROGEN CONTROLLED VACUUMED PACKED MOISTURE RESISTANT, COATED ELECTRODE

Characteristics

DM7018 H4R is a moisture resistant, hydrogen controlled, vacuum packed, basic coated electrode which is welder friendly and is recommended for welding of mild and medium carbon steel, high strength steel, cast steel and problematic steels. The electrode is vacuum packed and hence does not require expensive redrying at 250°C for 2 hours or a higher temperature. The weld metal is clean and has lowest level of impurities thus having unique properties of resistance to ageing.

Typical Applications on Usage

All maintenance applications including welding of all types of carbon-manganese steels, high tensile, heavy structures, plants and subject to static or dynamic loading.
It can be used as a buffer layer before hard facing.

RE-DRY CONDITIONS: No need of drying. The electrodes are vacuum packed hence can be used straight on the job.

Diffusible Hydrogen: < 4ml / 100gm weld metal

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.10 max	0.80 - 1.60	0.75 max	0.030 max	0.030 max	0.30 max	0.20 max	0.30 max	0.08 max

All Weld Mechanical Properties

YS (N/mm²)	UTS (N/mm²)	EL % (1=4d)	CHARPY "V" NOTCH IMPACT AT
450 - 520	520 - 600	24 - 32	-40°C : > 60

Sizes available and recommended currents (DC +) or AC 70V

SIZE	3/32	1/8	5/32	3/16
AMPS	70 ~ 100	100 ~ 140	140 ~ 190	190 ~ 240

POLARITY: DCEP or AC 70V
DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration
AC: medium weld penetration (can be more spatter)
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930