DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM7018 Premium Electrode

Classification: **E7018**

AWS A 5.1 / ASME SFA 5.1

DuraMax DM7018 is a HYDROGEN CONTROLLED BASIC COATED IRON POWDER TYPE ELECTRODE FOR WELDING LOW AND HIGH TENSILE STEELS

Characteristics

A Heavy coated, hydrogen controlled, basic coated, iron powder type electrode specially designed for restrained joints subjected to dynamic loading and to achieve minimum 110% metal recovery, possess, excellent mechanical properties, weld deposits are highly ductile, crack resistant and of radiographic quality.

Typical Applications on Usage

1) Blast furnace, Offers Drilling rigs and flat forms.
2) Penstocks heavy structures subjected to dynamic loading and impact.
3) Rail wagons, coaches.
4) Industrial & mining machinery, bridges, boiler fabrication.
5) Steels subjected to service at -30°C down sub-zero temperature.
6) Machinery for Earth moving and road equipment.
7) Atomic reactor shell and pipe work.
8) Frigates & submarines.

RE-DRY CONDITIONS: Re-Dry the electrode at 250°C-300°C for one hour before use.

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	510 - 620	22 - 32	-30°C : 60 - 100 J

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

SIZE	3/32	1/8	5/32
AMPS	70 ~ 100	100 ~ 130	140 ~ 180

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