

# NOUVE<sup>®</sup> 7018-1

Designation

**AWS A5.1 E7018-1**  
**UNS No. W07018**

Welding Positions



## Features

- Excellent arc characteristics
- Low moisture re-absorption
- Low spatter level
- Low smoke level
- Quick and easy slag removal
- Radiography quality

## Applications

Used extensively in welding of Carbon steel, low alloy structural steel, steel sensitive to hydrogen embrittlement, heavy and rigid structures, pressure vessels.

## Type of Current

Direct Current Electrode Positive (DCEP)

## Recommended Welding Techniques

GENERAL : Electrode positive, work negative (DCEP)  
 ARC LENGTH : Short arc  
 STORAGE : Re-dry electrodes to 300°C for 2 hours before use.  
 PRE HEAT : -

## Weld Metal Chemistry

	Carbon	Manganese	Silicon	Phosphorous	Sulphur	Nickel	Chromium	Molybdenum
Spec	0.15	1.6	0.75	0.035	0.035	0.30	0.20	0.30
Typical	0.07	1.2	0.34	0.009	0.01	0.22	0.14	0.226

## Mechanical Properties (as welded)

MECHANICAL TESTS	Tensile Strength	Yield Strength	Elongation %	Impact Energy	PWHT
AWS SPEC	490	400	22	27 J at -45 °C	NA
TYPICAL	535	24	24	32 J	NA