

## CA 7018

A low Hydrogen "Lo Temp" electrode designed for X-ray quality welds on mild steels, medium carbon and low alloy strength steels. Deposits offers resistance to hydrogen-induced embrittlement.

### Applications:

It is an all positional electrode for joining of medium carbon low alloy steels and machining steel without porosity or cracking. The deposits are radiographic type having very high physical properties. Applications include pipelines, tankers, crane booms, steel gears, loco frames etc.

### Procedure:

Clean weld area to remove surface contamination and gouge/grind all cracks; Maintain a short arc (can be used for 'contact welding' also); Use electrode on AC/DC + at the lowest amps; Allow to cool and slag is removed easily. Preheat is usually not necessary unless very heavy sections are involved.

<b><u>Technical Data</u></b>	:	<b>CA 7018</b>		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	100 - 140	130 – 170	160 – 200
Tensile Strength	:	55-60 kgf/ mm <sup>2</sup>		
Yield Strength	:	44 kgf/ mm <sup>2</sup> (min.)		
Elongation (l = 5d)	:	25% min.		
CVN Impact Strength	:	75 J (min.) at – 20 <sup>0</sup> C		

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