

Typical Applications:

- General Fabrication
- Boiler and Pressure Vessel
- Bridge and Structural Steel Fabrication
- Casting Repair
- Shipbuilding
- Repair and Maintenance

Product Advantages:

- Low Hydrogen
- All Position – Flat, Horizontal, Vertical
- Minimal moisture pickup
- Flat bead with easy slag release
- Consistent Arc Re-strike

Typical Mechanical Properties

	UTS (ksi)	Yield (ksi)	%El	CVN (ft/lbs) @ -20F
AWS Spec.	75	60	29	20
DevShield 7018	72	60	33	22

Typical Deposit Composition

	%C	%Mn	%Si	%Ni	%Mo	%Cr	%V
AWS Spec. (max.)	0.15	1.60	0.75	0.30	0.30	0.20	0.08

Available Diameters: 1/8", 5/32", 3/16", 7/32" (Additional sizes may be available upon request)

Typical Welding Parameters (DCEP)

Diameter	Amperage Range	Current
1/8"	100 – 150	DCEP
5/32"	130-200	DCEP
3/16"	200 – 225	DCEP
7/32"	225 – 250	DCEP

Packaging: Electrodes are vacuum-sealed in 10 lb. boxes in a climate-controlled room to eliminate all moisture and then placed in 40 lb. master cartons.

Moisture Control: Devasco electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40° F to 120° F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 500-800°F in a warming oven for a minimum of one hour prior to use to help reduce the moisture content.

NOTICE: Data provided is based on typical results. **Actual results are tested per customer spec.** Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. www.devasco.com for additional information.

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