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- › [magmaweld](#) /
- › [Magmaweld E7018 Welding Electrode Rod User Manual](#)

magmaweld E7018 5LB 1/8" (Model: 11204NJFM3)

Magmaweld E7018 Welding Electrode Rod User Manual

Model: E7018 5LB 1/8" (Part Number: 11204NJFM3) | Brand: Magmaweld

1. PRODUCT OVERVIEW

The Magmaweld E7018 welding electrodes are designed for high-quality, professional welding applications. These electrodes are known for producing X-ray quality welds with outstanding mechanical properties, making them ideal for critical structures such as bridges, tanks, pipelines, and heavy machinery. They offer a stable arc, low spatter, and easy slag removal, ensuring a clean and efficient welding process.



Image: A box of Magmaweld E7018 welding electrodes, showing the individual rods.

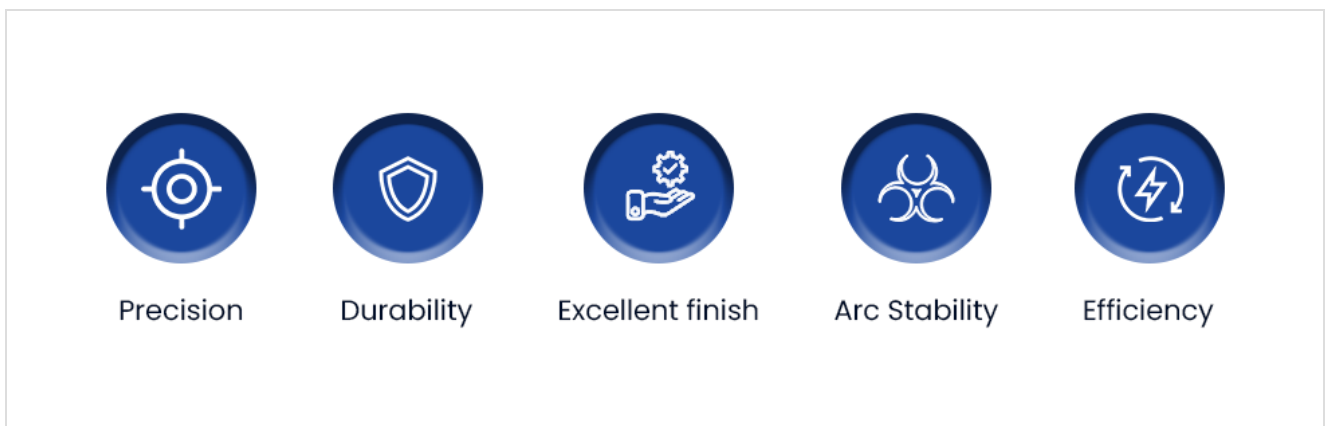


Image: A welder in action, demonstrating the use of E7018 welding electrodes for smooth and efficient welding.

2. SAFETY INFORMATION

Always prioritize safety when working with welding equipment and materials. Failure to follow safety guidelines can result in serious injury or death.

- **Personal Protective Equipment (PPE):** Always wear appropriate welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes.
- **Ventilation:** Ensure adequate ventilation to remove welding fumes and gases from the work area.
- **Fire Prevention:** Keep a fire extinguisher nearby. Remove all flammable materials from the welding area.
- **Electrical Safety:** Inspect welding cables and equipment for damage before use. Ensure proper grounding.

- **Eye and Skin Protection:** Protect eyes and skin from arc rays and hot metal.
- **Electrode Handling:** Handle electrodes with dry gloves. Avoid contact with bare skin.

3. KEY FEATURES

The Magmaweld E7018 electrodes offer several advantages for professional welders:

- **Professional Quality Welds:** Delivers X-ray quality welds for high-strength applications like bridges, tanks, pipelines, and heavy machinery.
- **Precision & Efficiency:** Optimized for welding medium and high-strength steels, offering excellent mechanical properties and durability.
- **Smooth Arc Performance:** Ensures a stable, low-spatter arc with easy slag removal for a clean, professional finish.
- **High Metal Recovery Rate:** Provides a 115% metal recovery rate, ensuring consistent and efficient weld deposits.
- **Trusted Brand Legacy:** Built with Magmaweld's 60 years of welding expertise, ensuring reliability, quality, and performance with every weld.



Image: Visual representation of key features: Precision, Durability, Excellent finish, Arc Stability, and Efficiency.



E7018 WELDING ELECTRODE ROD SMOOTH

Image: A diagram highlighting the design features of the electrode container, emphasizing its suitability for professionals.

DESIGNED FOR PROFESSIONALS

Known for producing X-ray quality welds with outstanding mechanical properties

Engineered for smooth arc performance, they minimize spatter.

Feature an easily removable head for an excellent finish.

These electrodes are optimized for welding medium and high-strength steels



Image: A welder at work, illustrating the high metal recovery rate achieved with these electrodes, leading to efficient weld deposits.



HIGH METAL RECOVERY RATE

Provides a 115% metal recovery rate, ensuring consistent & efficient weld deposits

Image: Collage showing various high-strength applications where these electrodes produce professional quality welds, including bridges, tanks, pipelines, and heavy machinery.

4. SETUP AND PREPARATION

Proper setup is crucial for achieving optimal welding results and ensuring safety.

1. **Work Area Preparation:** Clear the welding area of any flammable materials. Ensure good ventilation.
2. **Power Source:** Connect your welding machine to a suitable power source according to its specifications.
3. **Electrode Selection:** Ensure you are using the correct E7018 electrode size (1/8" for this product) and type for your application.
4. **Electrode Holder and Ground Clamp:** Connect the electrode holder and ground clamp securely to your welding machine.
5. **Workpiece Preparation:** Clean the workpiece thoroughly to remove rust, paint, oil, or any contaminants that could affect weld quality.
6. **Preheating (if necessary):** For certain high-strength steels or thick sections, preheating may be required to prevent cracking. Consult welding codes or material specifications.

5. OPERATING INSTRUCTIONS

E7018 electrodes are low-hydrogen electrodes, requiring specific handling and welding techniques for best performance.

- **Current Type:** E7018 electrodes can be used with both AC (Alternating Current) and DC (Direct Current) reverse polarity (DCEP/DC+). DC reverse polarity is generally preferred for better arc stability and penetration.
- **Amperage Settings:** Refer to the electrode manufacturer's recommended amperage range. For 1/8" (3.2mm) E7018 electrodes, a typical range is 90-150 amps, but this can vary based on joint type, position, and material thickness.
- **Arc Length:** Maintain a short arc length. This helps to maintain the shielding gas and prevent porosity.
- **Travel Speed:** Maintain a consistent travel speed to ensure proper bead width and penetration. Too fast can

lead to shallow penetration; too slow can lead to excessive heat input and distortion.

- **Electrode Angle:** Hold the electrode at a slight drag angle (10-30 degrees from vertical in the direction of travel).
- **Weaving Technique:** A slight weave can be used to control bead width and penetration, but avoid excessive weaving which can lead to slag inclusions.
- **Slag Removal:** After each pass, allow the weld to cool slightly, then chip off the slag. E7018 slag is typically easy to remove.

6. MAINTENANCE AND STORAGE

Proper storage and handling of E7018 electrodes are critical to maintain their low-hydrogen properties and prevent moisture absorption.

- **Storage:** Store electrodes in a dry, sealed container or a heated electrode oven (rod oven) to prevent moisture pickup. Moisture can lead to hydrogen embrittlement and porosity in welds.
- **Rebaking:** If electrodes have been exposed to moisture, they may need to be rebaked according to manufacturer specifications to restore their low-hydrogen properties.
- **Handling:** Handle electrodes carefully to avoid damaging the flux coating. A damaged coating can lead to unstable arcs and poor weld quality.
- **Expiration:** While electrodes don't typically expire, their performance can degrade if not stored correctly over long periods.

7. TROUBLESHOOTING

Common issues encountered when welding with E7018 electrodes and their potential solutions:

Problem	Possible Cause	Solution
Difficulty striking/maintaining arc	Low amperage, damp electrodes, poor ground connection, improper technique, brittle flux.	Increase amperage, rebake electrodes, check ground clamp, practice striking technique, inspect electrode for flux damage.
Excessive spatter	Too high amperage, long arc length, incorrect polarity.	Reduce amperage, shorten arc length, ensure DCEP/DC+ polarity.
Porosity (holes in weld)	Damp electrodes, contaminated base metal, too long arc, insufficient shielding.	Rebake electrodes, clean base metal, shorten arc, ensure proper ventilation (avoid drafts).
Slag inclusions	Improper cleaning between passes, excessive weaving, incorrect electrode angle.	Thoroughly clean slag, reduce weave, adjust electrode angle.
Undercutting	Too high amperage, too fast travel speed, incorrect electrode angle.	Reduce amperage, slow down travel speed, adjust electrode angle.

8. TECHNICAL SPECIFICATIONS

Specification	Detail
Manufacturer	Magmaweld

Specification	Detail
Part Number	11204NJFM3
Item Weight	5 pounds
Package Dimensions	14 x 2 x 2 inches
Size	1/8"
Material	E7018 5LB
Item Package Quantity	1
Date First Available	November 5, 2024

9. WARRANTY AND SUPPORT

For specific warranty information and technical support regarding your Magmaweld E7018 welding electrodes, please refer to the official Magmaweld website or contact their customer service directly. Keep your purchase receipt as proof of purchase.

For further assistance, you may also contact the seller, Weldingforless, through the platform where the purchase was made.