

CELLULOSIC FAST-FREEZING E6010 PIPE ELECTRODE

ISOARC EASY LH E7018 is a premium quality low hydrogen electrode designed for welding carbon and low alloy steels. It combines excellent mechanical properties with exceptional operator friendliness. The specially engineered coating delivers effortless arc starting, reliable restriking, smooth arc characteristics and easy slag removal, making it ideal for workshop fabrication, maintenance and structural applications.

Features & Benefits	Typical Applications
- Deeply penetrating, forceful arc for complete root pass fusion - Fast freezing slag ensures easy control in vertical down positions - Thin, crisp slag structure that easily brushes clean - Tolerates surface rust, scale, and minor moisture - Suitable for DC(+) (reverse polarity) - All-position welding	- Structural steel fabrication - General engineering - Pressure vessels - Mining and quarry equipment - Construction - Maintenance & repair - Agricultural equipment - Heavy fabrication

Technical Information

Classification	AWS A5.1 E7018
Polarity	AC / DCEP
Welding Positions	Flat ■ Horizontal ■ Vertical Up ■ Overhead
Base Materials	Carbon steels and low alloy steels
Storage	Store dry. Holding oven 100–150°C after opening.

Mechanical Properties	Typical	Typical Chemical Composition	
Tensile Strength	470 – 540 MPa		
Yield Strength	≥ 390 MPa		
Elongation	≥ 22%		

Current Range	
2.5mm	70 - 100A
3.2mm	90 - 140A
4.0mm	120 - 180A
5.0mm	170 - 240A



Manufactured by Thuthuka Welding Products (Pty) Ltd

Manufactured under an ISO 9001 quality management system using internationally proven formulations to deliver consistent welding performance and dependable quality.