

HABCO REARC 18 (S)

A MICRO DENSE COATED SUPERIOR ALL-POSITION CONTROLLED HYDROGEN ELECTRODE, FOR FABRICATION, MAINTENANCE AND REPAIR WELDING OF MEDIUM CARBON, LOW ALLOY AND CAST STEELS

FEATURES

HABCO REARC 18 with its specially formulated micro dense coating has unprecedented re-strike performance, and will resist moisture pick-up under extreme conditions of heat and relative humidity. This feature greatly reduces the risk of hydrogen induced cracking, and will produce x-ray quality welds with superior impact properties even in sub-zero temperatures. **Metal recovery of 120%.**

APPLICATIONS

For welding of medium carbon, low alloy and cast steels where ductility, impact strength and crack resistance are important. Ideally suited for;

- **Maintenance welding of mining and construction equipment.**
- Fabrication of "H" and "I" beams, angle and channel iron, pipelines and all other structural steels.
- Circular tube welds and other types of joints subject to stress and strain.

INSTRUCTIONS

Area to be welded should be cleaned in accordance with standard welding practice. Maintain close arc length. Vertical joints should be welded from bottom up, using low hydrogen technique. Do not whip. Use drag technique for horizontal fillet welds. Slag is easily removed.

Tensile Strength: up to 94,000 Psi (66 kg/mm²)

Elongation: up to 35%

Impacts: Charpy V Notch; 171 ft. lbs. @ -4°F (-20°C); 97 ft. lbs. @ -49°F (-45°C)

Current: AC or DC +

Amperage:	60-100	90-140	130-180	210-275	240-350
Diameters: (in)	3/32	1/8	5/32	3/16	1/4
(mm)	2.5	3.25	4.0	5.0	6.0

- **Certified by CWB to CSA STANDARD W48.1**
- **Conforms to AWS A5.1 E7018-1**