

HABCO REARC 18 PLUS (S)

A MICRO DENSE COATED SUPERIOR ALL POSITION CONTROLLED-HYDROGEN ELECTRODE FOR HIGH PRESSURE, LOW ALLOY AND BOILER STEELS

FEATURES

REARC 18 PLUS has a specially formulated **micro-dense coating providing superior moisture resistance** and smooth operating characteristics. Excellent for boiler, vessel and piping with service temperatures up to 970°F. Produces dense x-ray quality welds featuring a smooth transfer reducing the risk of undercut. Deposits highly crack resistant welds without porosity, in all positions. **Metal recovery of 120%**.

APPLICATIONS

Recommended for use on high tensile strength steels, in fabrication of boilers, pressure piping and pressure vessel applications, also for use on low alloy molybdenum steels.

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 89,000 Psi (63 kg/mm²)

Yield Strength: up to 72,000 Psi (51 kg/mm²)

Elongation: up to 32 %

Current: AC or DC +

Amperage:	90-155	140-210
Diameters: (in)	1/8	5/32
(mm)	3.25	4.0

- **Conforms to AWS A5.5 E7018-A1**