

Freedom **ALLOYS** Scorpion



THE NEW SUPER E-7018 WELDING ELECTRODE

Features of Scorpion:

- Moisture resistant coating.....
- Higher tensile strength.....
- Higher elongation.....
- Meets AWS/ASME specifications, each rod is marked E-7018.....
- Has unusually good AC welding characteristics.....
- Non-conductive.....
- Extremely smooth and easy to run.....

Benefits of Scorpion:

- Eliminates waste due to wet flux
- Stronger, more dependable welds
- Less brittle welds and cracking
- Can be used in all critical applications
- Can be used with all types of machines
- No side arcing when welding in tight spots
- Can be used by novice as well as certified welders.

	1/8	5/32
Part No.	10595	10596
Pkg. Qty	50#	50#
Amp Range	100 - 140 AMPS	140 - 190 AMPS
Length	14"	14"



INDUSTRIES

- Agriculture
- Aircraft
- Automotive
- Bottling
- Cement
- Chemical
- Construction
- Dairy
- Earthmoving
- Farming
- Food Process
- Hospitals
- Lumber
- Machine Shop
- Manufacturing
- Marine
- Mining
- Power Plants
- Pulp & Paper
- Public Utilities
- Quarries
- Railroads
- Refineries
- Steel Mills

APPLICATIONS

- Angle Iron
- Beams
- Boilers
- Brackets
- Bridges
- Carbon Steel
- Farm Equipment
- Furniture
- Galvanized Metal
- Heavy Duty Equipment
- Garbage Containers
- Machine Guards
- Mild Steel
- Pipe
- Plate
- Shafts
- Structural Steel
- Tanks
- Truck Bodies
- T-1 Steel

See reverse side for Technical Information and Procedures

Contact your TIFCO/Freedom Alloys Sales Representative or call for details

P.O. BOX 1478, CYPRESS, TEXAS 77410-1478 PHONE: 281.807.0757

INTERNET: www.freedomalloys.com

EMAIL: sales@freedomalloys.com

Technical Hotline: 800.980.2164

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TECHNICAL DATA

Tensile Strength	84,000 psi
Yield Strength	69,000 psi
Elongation	32%
Specifications	AWS/ASME IIC SFA 5.1 E7018

WELDING PROCEDURES

- Clean weld area & chamfer or bevel as needed with the "Eraser" electrode.
- Preheat to base metal requirements when welding high carbon or alloyed steels.
- Use short arc and backwhip weld at the end of the bead to prevent crater cracking.
- Peen weld immediately after breaking the arc, to mechanically relieve internal stresses & reduce cracking.

BF #92863

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