

# Polaris® 18

## Shielded Metal Arc Welding (SMAW – Stick)

For maintenance and fabrication of construction grade steel.

### Features

- Excellent Coating Stability
- Meets or Exceeds A.W.S. E-7018 Specifications
- Machinable Weld Deposits
- 82,000psi Tensile Strength
- 63,000psi Yield Strength
- Charpy At 82 ft/lbs

### Characteristics

**Polaris 18** was developed as a superior replacement for standard 7018. **Polaris 18** is ideal for the repair or joining of construction grade steel, or for fabrication/repair of angle iron, channel, I-beams, H-beams, pipe, cold rolled steel, mild steel, low alloy steel and hot, rolled steel.

### Technical

Size and Amps AC/DC ±20%

Inches	3/32	1/8	5/32
(mm)	(2.4)	(3.2)	(4.0)
Amps	85	120	160

With DC use reverse polarity. (DCEP)

### Application

- Clean and prepare base metal in accordance with the recommended welding practice.
- Maintain a lead angle of 15° to 20° with a medium arc length.
- Remove slag between passes.