

FOR HIGH TENSILE  
STRENGTH STEEL

AWS E10018-M  
JIS D7016  
KS D7016

# K-10018M

## Typical applications

Welding of 690N/mm<sup>2</sup> class high strength low alloy steel of pressure vessels, bridges, machinery and penstocks.

## Coating

Low hydrogen, iron powder type

## Characteristics on Usage

- ① Good mechanical properties.
- ② Excellent slag removal.
- ③ Redry the electrode at 300~350°C for 60 minutes prior to use.

## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Ni	Mo
0.07	0.46	1.35	0.14	1.63	0.28

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	Charpy V-notch J {kgf · m} (-51°C)
640 {65}	750 {77}	29	70 {7}

## Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	3.2	4.0	5.0	6.0	
Length (mm)	350	400	400	450	
Amp.	F	90~130	130~180	180~240	250~320
	V&OH	80~115	110~170	140~200	—

## Welding positions



Approved by