

K-11018M

AWS E11018-M
JIS D8016
KS D8016

FOR HIGH TENSILE
STRENGTH STEEL

Typical applications

Welding of low alloy high strength low alloy steels having tensile properties of about 740~790N/mm² such as HY80, etc.

Coating

Low hydrogen, iron powder type

Characteristics on Usage

- ① Excellent operational performance in all positions.
- ② Good impact value at -51°C.
- 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
0.08	0.41	1.49	0.32	1.86	0.32

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (-51°C)
720 {73}	820 {84}	23	60 {6}

Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0	
Length (mm)	350	350	400	400	450	
Amp.	F	50~100	90~130	130~180	180~240	250~320
	V&OH	40~90	80~120	110~160	140~200	-

Welding positions



Approved by