FOR HIGH TENSILE STRENGTH STEEL

AWS E12018-M

K-12018M

Typical applications

Welding of 890N/mm² 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 of weld metal especially impact value.
② Redry the electrode at 300~350℃ for 60 minutes prior to use.

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

C	Si	Mn	Cr	Ni	Mo
0.08	0.30	1.46	0.98	1.86	0.41

Typical mechanical properties of all-weld-metal

Y · P N/mm²{kgf/mm²}	T · S N/mm²{kgf/mm²}	El (%)	Charpy V-notch J {kgf · m} (-51℃)
800 {82}	950 {97}	20	50 {5}

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	70~100	90~130	150~190	180~230	220~300
	V&OH	60~90	70~100	120~160	140~180	–

Welding positions

Approved by