FOR HIGH TENSILE STRENGTH STEEL

AWS E7018
JIS D5016
KS D5016

K-7018

Typical applications

Welding of 490N/mm² class high tensile strength steels of ships, bridges, storage tanks, building, industrial machinery and mining machinery.

Coating

Low hydrogen, iron powder type.

Characteristics on Usage

① Excellent usability with direct current applications.
② Redry the electrode at 300~350℃ for 60 minutes prior to use.

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

C	Si	Mn	P	S
0.07	0.57	0.97	0.012	0.010

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} (-29℃)
480 {49}	570 {58}	30	90 {9}

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	60~100	90~130	130~180	200~250	250~310
	V&OH	50~80	80~120	110~170	160~210	–

Welding positions

Approved by

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS, KS