

FOR HEAT-
RESISTING STEEL

AWS E7018-A1

K-7018A1

Typical applications

Welding of high strength low alloy steel of 450N/mm² minimum yield point and 0.5%Mo steel of pressure piping, casting and general fabrication of pressure vessel.

Coating

Low hydrogen, iron powder type.

Characteristics on Usage

- ① High deposition rate in all positions.
- ② Preheat at 100~200°C and postheat treat at 620~680°C.
- ③ Redry the electrode at 350~400°C for 30~60 minutes prior to use.

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

C	Si	Mn	Mo
0.06	0.49	0.72	0.53

Typical mechanical properties of all-weld-metal

Temp.	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	PWHT
R.T	590 {60}	680 {69}	28	620°C × 1hr. S · R
500°C	500 {51}	540 {55}	22	

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	60~90	80~120	130~180	190~240	240~300
	V&OH	50~80	70~110	100~160	-	-

Welding positions



Approved by