

K-7018N

AWS E7018-1

FOR LOW TEMPERATURE SERVICE STEEL

Typical applications

Welding of nuclear reactor vessels, pressure vessels, LPG tankers, LPG storage tanks and similar installations at low temperature.

Coating

Low hydrogen, iron powder type.

Characteristics on Usage

- ① Excellent impact value at -46°C
- ② Excellent mechanical properties.
- ③ Redry the electrodes at $300\sim 350^{\circ}\text{C}$ for 30~60 minutes prior to use.

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

C	Si	Mn	Ni
0.07	0.58	1.38	0.15

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} (-46°C)
510 {52}	590 {60}	32	130 {13}

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	160~220	180~230
	V&OH	60~90	85~120	110~160	130~180	-

Welding positions



Approved by

CWB, DNV, LR