

**FOR HIGH TENSILE
STRENGTH STEEL**

**AWS E8018-G
JIS D5316
KS D5316**

K-8018

Typical applications

Welding of 540N/mm² class high strength low alloy steel of ships, bridges, storage tanks and buildings.

Coating

Low hydrogen, iron powder type.

Characteristics on Usage

- ① Good mechanical properties and crack resistance of the deposited weld metal.
- ② Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Ni	Mo
0.06	0.54	1.08	0.31	0.20

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	El (%)	Charpy V-notch J {kgf · m} (-29°C)
490 {50}	590 {60}	28	150 {15}

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	90~130	140~190	180~230	250~300
	V&OH	50~80	80~110	120~170	160~200	-

Welding positions



Approved by

ABS, JIS