

K-8018C2

AWS E8018-C2

FOR LOW TEMPERATURE SERVICE STEEL

Typical applications

Welding of 3.5%Ni steel and aluminium-killed steel used at low temperature, LPG tanker where high impact properties are necessary at -73°C.

Coating

Low hydrogen, iron powder type.

Characteristics on Usage

- ① Fast, efficient metal transfer in all positions.
- ② Excellent notch toughness of the deposited weld metal at low temperature.
- ③ Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Ni
0.07	0.32	1.12	3.45

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) (-73°C)	PWHT
580 {59}	680 {69}	22	60 {6}	As welded
570 {58}	650 {66}	23	80 {8}	620°C×1hr. S·R

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 V&OH 50~80	90~130 80~120	135~180 110~170	190~240	250~310

Welding positions



Approved by