

FOR LOW TEMPE-
RATURE SERVICE STEEL

AWS E8018-C3

K-8018C3

Typical applications

Welding of 1%Ni and high tensile strength steel for military and commercial applications where good impact property and minimum 590N/mm² tensile strength is needed.

Coating

Low hydrogen, iron powder type.

Characteristics on Usage

- ① Fast, efficient metal transfer in all positions.
- ② Excellent deposited weld metal with both AC and DC power source.
- 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	0.45	0.91	1.03

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} (-30°C) (-40°C)	
530 {54}	600 {61}	31	80 {8}	60 {6}

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp.	F	60~95	90~130	135~180	190~240
	V&OH	60~90	80~120	110~170	-

Welding positions



Approved by

ABS, LR