

# K-9018M

AWS E9018-M  
JIS D5816  
KS D5816

FOR HIGH TENSILE  
STRENGTH STEEL

## Typical applications

Welding of 590N/mm<sup>2</sup> class high strength low alloy steel of pressure vessels, bridges, machinery and penstocks.

## Coating

Low hydrogen, iron powder type

## Characteristics on Usage

- ① Excellent mechanical properties especially in notch toughness.
- ② Excellent radiographic soundness.

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

C	Si	Mn	Cr	Ni	Mo
0.07	0.51	1.10	0.10	1.58	0.20

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	Charpy V-notch J {kgf · m} (-51°C)
570 {58}	670 {68}	30	90 {9}

## 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	50~100	90~130	140~190	190~240	250~310
	V&OH	40~80	80~115	110~160	140~170	-

## Welding positions



Approved by