

K-8018

For 560MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 46 3 B 32 H10	KS D 7006	: E5316
EN ISO 2560-B:2006	: E 55 18-G A H10	JIS Z 3211	: E5518-G
AWS A5.5-06	: E8018-G		

Description

- Covering is low hydrogen, iron powder type for welding of 560MPa class high tensile steel in ships, bridges, penstocks and rails.
- Excellent mechanical properties and radiographic soundness.
- Satisfactory bead appearance and slag removal.
- Redry the electrode at 300 – 400 °C for 1 – 2 hours prior to use.



Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.56	1.32	0.018	0.011	0.35	0.03	0.25	0.01

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-20 °C	-30 °C	
AWS A5.5	Min. 460	Min. 550	Min. 19			
EN ISO 2560-A	Min. 460	530-680	Min. 20		≥ 47	
Example	490	590	28	95	80	AW

*AW: As-welded

Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amperage	F	60-90	90-130	140-190	180-230	250-310
(A)	V . OH	50-80	80-110	120-170	160-200	-

Approvals

ABS

3YH10, E7018

*Others: JIS, CE