

# K-7018NP

For 490MPa high tensile steel

## Classifications

EN ISO 2560-A:2006	: E 42 4 B 42 H5
EN ISO 2560-B:2006	: E 49 18-1 A U H5
AWS A5.1-04	: E7018-1 H4R
JIS Z 3211	: E4918-1 H5

## Approvals

ABS	: 3YH5
BV	: 3YH5
DNV	: 3YH5
LR	: 3YmH5

## Description

- Covering is low hydrogen, iron powder type for welding of nuclear reactor vessels, LPG tankers, LPG storage tanks and similar installations at low temperatures
- Good impact properties at -45 °C
- Excellent mechanical properties and radiographic soundness
- 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*	*Sum
0.05	0.45	1.18	0.013	0.012	0.25	0.03	0.01	0.02	1.49

## Typical mechanical properties of all-weld metal

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Value (J)		Remarks
				-30 °C	-45 °C	
AWS A5.1	Min. 400	Min. 490	Min. 22		≥ 27	
EN ISO 2560-A	Min. 420	500-640	Min. 20	≥ 47		
Example	510	570	32	110	75	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	70-100	90-130	150-190	160-220	180-230
	V . OH	60-90	85-120	110-160	130-180	-