

K-8018C1

For low temperature service steel (560Mpa)

Classifications

EN ISO 2560-A:2006	: E 46 6 2Ni B 32 H10
EN ISO 2560-B:2006	: E 55 18-N5 P U H10
AWS A5.5-06	: E8018-C1
JIS Z 3211	: E5518-N5 P U

Approvals

ABS	: 3YH10, E8018-C1
DNV	: 3YH15
LR	: 3YmH15
Other	: CE

Description

- Covering is low hydrogen, iron powder type for welding of 2.5%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Stable arc in flat and horizontal fillet welding
- Weld metal of fine ripple mark without undercut can be obtained
- 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	0.60	0.96	0.015	0.012	2.41	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Value (J)		Remarks
				-50 °C	-60 °C	
AWS A5.5	Min. 460	Min. 550	Min. 19		≥ 27	
EN ISO 2560-A	Min. 460	500-550	Min. 17		≥ 47	
Example	500	600	32	120	100	PWHT

*PWHT: 605 °C x 1Hr

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	65-100	90-130	130-190	190-250	250-300
	V . OH	60-90	85-120	110-160	-	-