

# K-7018 HR

For 490MPa high tensile steel

## Classifications

EN ISO 2560-A:2006	: E 42 3 B 32 H5	KS D 7006	: E5016
EN ISO 2560-B:2006	: E 49 18 A U H5	JIS Z 3211	: E4918 H5
AWS A5.1-04	: E7018 H4R		

## Description

- Covering is low hydrogen, iron powder type for welding of 490 MPa class of high tensile steel in ships, bridges, storage tank, building and industrial machinery.
- Good impact properties and very low hydrogen content. (HD ≤ 4ml/100g)
- Excellent bead appearance 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
0.07	0.60	0.98	0.015	0.012	0.02	0.03	0.01	0.01	1.05

## Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-20 °C	-30 °C	
AWS A5.1	Min. 400	Min. 490	Min. 22		≥ 27	
EN ISO 2560-A	Min. 420	500-640	Min. 20		≥ 47	
Example	550	620	29	110	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	60-100	90-130	130-180	200-250	250-310
(A)	V . OH	50-80	80-120	110-170	160-210	-

## Approvals

ABS	BV	DNV GL	LR	KR	NK
3YH5	3YH5	3YH5	3YmH5	3YH5	KMW53H5

\*Others: JIS, CCS, CE