

K-10018M

For 690MPa high tensile steel

Classifications

EN 757: 1997	: E 55 3 Z B 32 H10
AWS A5.5-06	: E10018-M
KS D 7006	: E7016
JIS Z 3211	: E6918-N3M2

Approvals

JIS, CE

Description

- Covering is low hydrogen, iron powder type for welding of 690MPa class high tensile steel in bridges, pressure vessels, penstocks and machinery
- Excellent mechanical properties especially in notch toughness
- 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
0.07	0.46	1.35	0.015	0.012	1.63	0.20	0.28	0.01

Typical mechanical properties of all-weld metal

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact Value (J)		Remarks
				-30 °C	-50 °C	
AWS A5.5	610-690	Min. 690	Min. 20		≥ 27	
EN 757	Min. 550	610-780	Min. 18	≥ 47		
Example	640	750	29	80	45	AW

* AW – As-Welded

Sizes available and recommended currents (AC or DC +)

Diameter	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amperage	F	90-130	130-180	180-240	250-320
	V . OH	80-115	110-170	140-200	-