

K-9018M

For high tensile steel (620Mpa)

Classifications

EN ISO 2560-A:2006	: E 50 5 Z B 32 H10
AWS A5.5-06	: E9018-M
KS D 7006	: E5816
JIS Z 3211	: E6218-N3M1

Approvals

ABS	: E9018M-H8
Other	: JIS, CE

Description

- Covering is low hydrogen, iron powder type for welding of 620MPa a 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
0.05	0.51	0.8	0.013	0.011	1.58	0.10	0.20	0.01

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)		Remarks
	(MPa)	(MPa)	(%)	-40 °C	-50 °C	
AWS A5.5	540-620	Min.620	Min. 24		≥ 27	
EN ISO 2560-A	Min. 500	560-720	Min. 18		≥ 47	
Example	570	670	30	110	90	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	50-100	90-130	140-190	190-240	250-310
	V . OH	40-80	80-115	110-160	140-170	-