

K-7018

For 490MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 42 3 B 32 H10	KS D 7006	: E5016
EN ISO 2560-B:2006	: E 49 18 A U H10	JIS Z 3211	: E4918
AWS A5.1-04	: E7018		

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.
- Excellent mechanical properties and radiographic soundness.
- 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*	*Sum
0.07	0.61	0.87	0.015	0.011	0.02	0.03	0.01	0.01	0.94

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		≥ 27	
Example	480	570	30	100	70	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
3YH10, E7018	-	3YH10	3YmH15	3YH15	KMW53H

*Others: KS, JIS, CWB, CE