



Covered Arc Welding Electrode for high tensile strength steels



K-7018

Typical Applications:

Welding of 490N/mm² class high tensile strength steels of ships, bridges, storage tanks, building, industrial machinery and mining machinery.

Coating: Low hydrogen, iron powder type.

Characteristics on Usage:

1. Excellent usability with direct current applications.
2. Redry the electrode at 300-350°C for 60 minutes prior to use.

Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S
0.07	0.57	0.97	0.012	0.010

Typical mechanical properties of all weld metal

Y-P N/mm ² {kgf/mm ² }	T-S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J-{kgf-m} (-29°C)
480 {49}	570 {58}	30	90 {9}

Sizes available and recommended currents (AC or DC+)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0
Length (mm)	350	350	400	400	450
AMP F	60-100	90-130	130-180	200-250	250-310
V & OH	50-80	80-120	110-170	160-210	-----

Welding positions



Approved by

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS, KS

