

Covered Electrodes

K-8018C2

For low temperature service steel (560MPa)

Classifications

EN ISO 2560-A:2006	: E 46 6 3Ni B 32 H10	JIS Z 3211	: E5518-N7 P
EN ISO 2560-B:2006	: E 55 18-N7 P H10		
AWS A5.5-06	: E8018-C2		

Description

- Covering is low hydrogen, iron powder type for welding of 3.5%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Fast, efficient metal transfer in all positions.
- Excellent notch toughness of the deposited weld metal at low temperature.
- 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	0.32	1.12	0.013	0.012	3.45	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-60°C	-75°C	
AWS A5.5	min. 460	min. 550	min. 19	≥ 27		
EN ISO 2560-B	min. 460	500~550	min. 17	≥ 27		
Example	530	620	28	55	40	PWHT

* PWHT : 605°Cx1Hr

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	60~90	90~130	135~180	190~240	250~310
(A)	V · OH	50~80	80~120	110~170	—	—