

Covered Electrodes

K-7018C3L

For low temperature service steel (490MPa)

Classifications

EN ISO 2560-A:2006	: E 42 3 1Ni B 32 H5	JIS Z 3211	: E4918-N2 H5
EN ISO 2560-B:2006	: E 49 18-N2 A H5		
AWS A5.5-06	: E7018-C3L H4R		

Description

- Covering is low hydrogen, iron powder type for welding of 1%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Fast, efficient metal transfer in all positions and very low hydrogen content. (HD ≤4ml/100g)
- 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
0.05	0.31	0.86	0.016	0.016	1.01	0.05	0.02	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-50°C	
AWS A5.5	min. 390	min. 490	min. 22	≥ 47	≥ 27	
EN ISO 2560-A	min. 420	500~640	min. 20	90	50	AW
Example	530	620	34			

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp. (A)	F V · OH	60~90 50~80	90~140 80~120	150~190 120~160	180~230 -

Approvals

CE