K-7018(PIPEWELD)

For 490MPa high tensile steel

Classifications

EN ISO 2560-A:2006	: E 42 3 B 32 H5	KS D 7006	: E5016
EN ISO 2560-B:2006	: E 49 18 A U H5	JIS Z 3211	: E4918 H5
AWS A5.1-06	: E7018 H4		

Description

- Covering is low hydrogen, iron powder type for welding of nuclear reactor vessels, LPG tankers, LPG storage tanks and similar installations at low temperature.
- Good impact value at -30℃
- Good usability with direct current applications.
- Excellent mechanical properties and radiographic soundness.
- Redry the electrode at 300~400℃ 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
0.05	0.54	1.02	0.015	0.015	0.02	0.03	0.01	0.01	1.09

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30℃	IV (J) -45℃	Remarks
AWS A5.1	min. 400	min. 490	min. 22		≥ 27	
EN ISO 2560-A	min. 420	500~640	min. 20		≥ 47	
Example	480	570	32	150	100	AW

* AW : As-Welded

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	70~100	90~130	150~190	160~220	180~230
(A) V · OH	60~90	85~120	110~160	130~180	–

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3YH10,E7018	3YHH	3YH10	3YH10	3YH5	3YmH5	KMW53H5

* Others : KS, JIS, CWB, CE