

Classifications

EN 757:1997 : E 55 3 Z B 32 H10
 AWS A5.5-06 : E10018-M

KS D 7006 : E7016
 JIS Z 3211 : E6918-N3M2

Description

- Covering is low hydrogen, iron powder type for welding of 690MPa class high tensile steel in bridge, pressure vessels, penstocks and machinery.
- Excellent mechanical properties especially in notch toughness.
- 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
0.07	0.46	1.35	0.015	0.012	1.63	0.20	0.28	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	610~690	min. 690	min. 20	≥ 47	≥ 27	
EN 757	min. 550	610~780	min. 18	80	45	AW
Example	640	750	29			

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amp. (A)	F V · OH	90~130 80~115	130~180 110~170	180~240 140~200	250~320 -

Approvals

JIS, CE