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℃ 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) -30℃ | IV (J) -50℃ | Remarks |
|---|---|---|---|---|---|---|
| AWS A5.5 | min. 390 | min. 490 | min. 22 | | ≥ 27 | |
| EN ISO 2560-A | min. 420 | 500~640 | min. 20 | ≥ 47 | | |
| Example | 530 | 620 | 34 | 90 | 50 | AW |

* 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. F | 60~90 | 90~140 | 150~190 | 180~230 |
| (A) V · OH | 50~80 | 80~120 | 120~160 | – |

## Approvals

CE