K-8018C3

For low temperature service steel (560MPa)

Classifications

EN ISO 2560-A:2006	: E 46 4 1Ni B 32 H10	JIS Z 3211	: E5518-N2 U
EN ISO 2560-B:2006	: E 55 18-N2 A U H10		
AWS A5.5-06	: E8018-C3		

Description

- Covering is low hydrogen, iron powder type for welding of 1%Ni steel and high tensile strength steel for military and commercial applications where good impact property.
- Fast, efficient metal transfer in all positions.
- Excellent deposited weld metal with both AC and DC power source.
- 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
0.07	0.45	0.91	0.013	0.012	1.03	0.02	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30℃	IV (J) -40℃	Remarks
AWS A5.5	470~550	min. 550	min. 24		≥ 27	
EN ISO 2560-B	min. 460	530~680	min. 20		≥ 47	
Example	530	600	28	100	60	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. (A)	F	60~95	90~130	135~180	190~240
	V · OH	60~90	80~120	110~170	–

Approvals

ABS	LR
3YH10,E8018-C3	3YmH15

* Others : CE