

Covered Electrodes

K-8018C1

For low temperature service steel (560MPa)

Classifications

EN ISO 2560-A:2006	: E 46 6 2Ni B 32 H10	JIS Z 3211	: E5518-N5 P U
EN ISO 2560-B:2006	: E 55 18-N5 P U H10		
AWS A5.5-06	: E8018-C1		

Description

- Covering is low hydrogen, iron powder type for welding of 2.5%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Stable arc in flat and horizontal fillet welding.
- Weld metal of fine ripple mark without undercut can be obtained.
- 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
0.06	0.60	0.96	0.015	0.012	2.41	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-50°C	-60°C	
AWS A5.5	min. 460	min. 550	min. 19		≥ 27	
EN ISO 2560-B	min. 460	500~550	min. 17		≥ 47	
Example	500	600	32	120	100	PWHT

* PWHT : 605°Cx1Hr

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	60~100	90~130	130~190	190~250	250~300
(A)	V · OH	60~90	85~120	110~160	—	—

Approvals

ABS	DNV	LR
3YH10,E8018-C1	3YH15	3YmH15

* Others : CE