

Covered Electrodes

K-7018HR

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 A5.1-04	: E7018 H4R		

Description

- Covering is low hydrogen, iron powder type for welding of 490MPa class high tensile steel in ships, bridges, storage tank, building and industrial machinery.
- Good impact properties and very low hydrogen contents. (HD ≤4ml/100g)
- Excellent bead appearance and radiographic soundness.
- 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*	*Sum
0.07	0.60	0.98	0.015	0.012	0.02	0.03	0.01	0.01	1.05

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.1	min. 400	min. 490	min. 22	≥ 27		
EN ISO 2560-A	min. 420	500~640	min. 20	≥ 47		
Example	550	620	29	110	80	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. (A)	F V · OH	60~100 50~80	90~130 80~120	130~180 110~170	200~250 160~210	250~310 -

Approvals

ABS	BV	DNV	GL	KR	LR	NK
3YH5	3YHHH	3YH5	3YH5	3YH5	3YmH5	KMW53H5

* Others : JIS, CCS, CE