

Covered Electrodes

K-8018D1

For 560MPa high tensile steel (Mn-Mo steel)

Classifications

EN ISO 2560-B:2006	: E 55 18-3M2 P H5	JIS Z 3211	: E5518-3M2 P H5
AWS A5.5-06	: E8018-D1 H4		

Description

- Covering is low hydrogen, iron powder type for welding of 560MPa class high tensile steel or 1.5%Mn-0.35%Mo steel.
- Very low hydrogen content. (HD ≤ 4ml/100g)
- Excellent mechanical properties and radiographic soundness.
- Good notch toughness at -50℃.
- 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	0.47	1.33	0.013	0.013	0.77	0.02	0.30	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-40℃	-50℃	
AWS A5.5	min. 460	min. 550	min. 19		≥ 27	
EN ISO 2560-B	min. 460	min. 550	min. 17		≥ 27	
Example	640	690	25	60	40	PWHT

* PWHT : 620℃x1Hr

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	70~100 60~90	90~150 80~130	150~190 120~170	190~260 140~200

Approvals

JIS, CE