

K-10018D2

For 690MPa high tensile steel (Mn-Mo steel)

Classifications

EN 757:1997 : E 55 3 Z B T 32 H5
AWS A5.5-06 : E10018-D2 H4

JIS Z 3211 : E6918-4M2 P H5

Description

- Covering is low hydrogen, iron powder type for welding of 560MPa class high tensile steel (ASTM A302 Gr.B) or 1.85%Mn-0.35%Mo steel.
- Very low hydrogen content. (HD $\leq$ 4ml/100g)
- Excellent mechanical properties especially in notch toughness.
- Satisfactory bead appearance and slag removal.
- 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
0.10	0.58	1.71	0.017	0.015	0.74	0.02	0.31	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-50°C	
AWS A5.5	min. 600	min. 690	min. 16		≥ 27	
EN 757	min. 550	610~780	min. 18	≥ 47		
Example	680	760	23	60	40	PWHT

* PWHT : 620°Cx1Hr

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