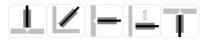
Stick Electrode for High Tensile Strength Steel				
	Classification			
	AWS A 5.1/A 5.1M		E7018/E4918	
KL-508	JIS	Z3211	E4918	
	EN	2560-A	E42 3 B 3 2	
Type of coating: Iron powder low hydrogen type	GB	T5117	E5018	

#### **Applications and Features**

- (1) Suitable for welding 490N/mm<sup>2</sup> grade steel.
- (2) High deposition rate, good mechanical properties of weld metal, good crack resistance and good X-ray soundness.
- (3) Applicable for welding on large steel structures, tanks, pressure vessels. Ideal for that require excellent quality and performance such as pipelines in power plants and petrochemical.

# Welding position



#### Welding Instruction

Please refer to Appendix A.

### Typical Chemical Composition of Weld Metal (wt%)

С	Si	Mn	Р	S	
0.07	0.30	1.20	0.019	0.006	

### **Typical Mechanical Properties of Weld Metal**

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm²	N/mm <sup>2</sup>	%	°C	J
555	465	31	-29 -40	148 112

## Size and Suggested Operating Range (AC or DC+)

Diame	eter (mm)	3.2	4.0	5.0	6.0
Current	F/H-Fillet	90~130	130~180	180~240	230~300
(A)	V-up/OH	80~120	110~160	150~200	-