

LKE-7018-1 H4



LINKWELD ALLOYS INC.

AWS	A5.1 E7018-1 H4
EN	EN499 E 46 4 B 3 2
JIS	Z3212 D5016

Characteristics:

LKE-7018-1 is a low hydrogen type electrode for the welding of 490N/mm² grade high tensile steel. It is designed for single and multiple pass applications. The welding can be done with good appearance, stable arc and low spatter. With excellent mechanical properties, impact value at temperature of -46°C and low diffusible hydrogen.

Applications:

It is suitable for welding of low alloy steels, medium carbon steels, heavy steel plates, cast steels, aluminum killed steel of LPG and especially for welding of steels with poor weldability.

Notes on Usage:

1. Dry the electrodes at 350-400°C for 1-2 hours before use.
2. Keep the arc as short as possible to prevent moisture pick-up.
3. Take the back-step method to prevent blowholes at the arc starting.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.070	1.40	0.47	0.02	0.004

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -46 °C J
500	580	29	88

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	450	450
Amps	F	80-100	130-150	160-190	200-240
	V&OH	70-100	90-150	130-160	170-200
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20