



LKE-7018-1

LINKWELD ALLOYS INC.

AWS	A5.1 E7018-1
EN	EN499 E 42 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. The welding can be done with high deposition rate, good X-ray soundness and mechanical properties. With excellent impact value at temperature of -46°C.

Applications:

It is suitable for welding of nuclear reactor vessels, pressure vessels, LPG tanks ect.

Notes on Usage:

1. Dry the electrodes at 300-350°C for 60 minutes and keep at 100-150°C before use.
2. Keep the arc as short as possible.
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
0.060	1.38	0.58	0.02	0.005

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -46 °c J
500	585	30	81

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	55-85	90-130	130-180	170-240
	V&OH	50-80	90-120	110-160	150-180
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20