



# LKE-7018-A1

LINKWELD ALLOYS INC.

AWS	A5.5 E7018-A1
EN	EN1599 E Mo B 3 2
JIS	Z3223 DT 1216

## Characteristics:

LKE-7018-A1 is an iron powder low hydrogen type electrode for 490N/mm<sup>2</sup> high tensile steel. It provides high welding efficiency due to the addition iron powder. The weld metal contains 0.5% Mo.

## Applications:

it is suitable for chemical plants, petroleum refinery plants and other casting steels.

## Notes on Usage:

1. Dry the electrodes at 350-400°C for 60 minutes before use.
2. Take the backstep method at the arc starting.
3. Keep the arc as short as possible.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Mo
0.080	0.78	0.54	0.012	0.013	0.56

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %	PWHT
490	575	31	620 °C x 1hr

## Welding position:



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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	400	400
Amps	F	90-140	140-190	190-240
	V&OH	80-120	120-160	-
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20