



LKE-7018-W1

LINKWELD ALLOYS INC.

AWS A5.5 E7018-W1
JIS Z3214 DA5016G

Characteristics:

LKE-7018-W1 is an electrode for the welding of 490N/mm² grade high tensile steel. With good atmospheric corrosion resistance, good X-ray soundness and good crack resistance.

Applications:

It is suitable for welding of high tensile steel such as ASTM A588, COR-TEN A,B and also SPA-H, SMA 490 steel.

Notes on Usage:

1. Dry the electrodes at 350-400°C for 60 minutes before use.
2. Take the back-step method at the arc starting to prevent blowholes.
3. Keep the arc as short as possible.
4. While applying in plate with high restraint (such as the plates is thicker than 25mm), preheat at 80-100 °c is recommended.
5. Do not exceed the range of recommended because over heat input might decrease the impact value.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cu	Ni	Cr
0.06	0.60	0.50	0.02	0.01	0.50	0.35	0.25

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -20 °c J
470	578	31	142

Welding position:



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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amps	F	100-140	140-180	180-230
	V&OH	80-130	120-160	-
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20