

AWS	A5.1 E7018
EN4	EN499 E 42 3 B 3 2
JIS	Z3212 D5016

Characteristics:

LKE-7018 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.

Applications:

It is especially suitable for nuclear power stations, petroleum chemical plants, and heavy steel plates.

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
0.080	1.30	0.60	0.012	0.011

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV , J	
			0 °C	-29 °C
			515	585

Welding position:



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

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	400	400
Amps	F	55-85	90-130	130-180	180-240
	V&OH	50-80	85-120	110-160	150-200
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20