

LKE-8018-B2



LINKWELD ALLOYS INC.

AWS	A5.5 E8018-B2
EN	EN1599 E CrMo1 B 3 2
JIS	Z3223 DT2318

Characteristics:

LKE-8018-B2 is an iron powder low hydrogen electrode. The weld metal contains 1.25%Cr-0.5%Mo that makes the electrodes more suitable at 550 °C, With the characters of quiet and stable arc, little spatter.

Applications:

It is suitable for welding of piping steels (STPA22,23, A335-P11, P12), casting steels (A217-WC6), and forging steels (A182-F11,F12).

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.
3. Keep the arc as short as possible.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Mo
0.080	0.80	0.60	0.012	0.010	1.40	0.54

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	PWHT
590	675	26	690°C x1hr

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