

LKE-8018-C1



LINKWELD ALLOYS INC.

AWS	A5.5 E8018-C1
EN	EN499 E 46 5 2Ni B 3 2
JIS	Z3241 DL5026-6P2

Characteristics:

LKE-8018-C1 is an iron powder low hydrogen electrode for the welding of low temperature service steel. Good impact value can be obtained at -60 °C. The weld metal contains 2.5%Ni, that will be suitable for the welding of low temperature service. The welding bead can be done with good X-ray soundness, equal fillet leg size, high efficiency, and nice bead appearance.

Applications:

It is suitable for high carbon steels, low Mn alloy steels, high tensile steels, cast steels, low temperature steel pipes, aluminum killed steels. Its features make the product being applied to shipbuilding, structural fabrication, bridge structure, pressure vessel.

Notes on Usage:

1. Dry the electrodes at 300-350 °C for 60 minutes before use.
2. Do not exceed the proper range of current, otherwise impact value will decrease.
3. Take the back-step method at the arc starting.
4. Keep the arc as short as possible.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni
0.080	0.98	0.64	0.014	0.008	2.55

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -60 °C J	PWHT
480	580	32	84	620°C x1hr

Welding position:



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

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	400	400
Amps	F	60-100	100-140	140-180	180-230
	V&OH	60-90	90-130	120-160	140-180
Weight per pack(kg)		5	5	5	5
Weight per carton (kg)		20	20	20	20