



LKE-8018-C2

LINKWELD ALLOYS INC.

AWS	A5.5 E8018-C2
EN	E499 E 46 6 3Ni B 3 2
JIS	Z3241 DL5026-6P3

Characteristics:

LKE-8018-C2 is an iron powder low hydrogen electrode for the welding of low temperature service steel. The weld metal contains 3.5%Ni. Good impact value can be obtained at -73 °C. The welding can be done with good X-ray soundness, high deposition rate.

Applications:

It is suitable for the welding LPG tanks or 3.5%Ni steel for low temperature service.

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
0.070	0.90	0.57	0.014	0.008	3.40

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -73 °C J	PWHT
470	570	32	108	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	70-100	100-140	140-180	180-230
	V&OH	60-90	90-130	120-160	-
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20