



AWS	A5.5 E8018-C3
EN	EN499 E 46 4 1Ni B 3 2
JIS	Z3241 DL5026-4A1

Characteristics:

LKE-8018-C3 is an iron powder low hydrogen electrode for the welding of low temperature service steel in all positions. The weld metal contains 1.0%Ni. The welding can be done with good X-ray soundness, high deposition rate, and good impact value at -45 °c.

Applications:

It is suitable for the welding of LPG tanks.

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 the 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	0.62	0.013	0.012	1.02

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -45 °c J
470	560	29	118

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