



LKE-E10018-G

LINKWELD ALLOYS INC.

AWS	A5.5 E10018-G
EN	EN757 E 62 5 Mn2NiMo B 3 2
JIS	Z3212 D7016

Characteristics:

LKE-10018-G is a low hydrogen electrode for the welding of 690 N/mm² grade high tensile steel. With excellent crack resistance, good mechanical property and bead appearance.

Applications:

It is suitable for build-up welding before hardfacing. Proper base metals are forging cast iron, structural steel(HT70), pressure vessel(ASTM A225 Gr.C), carbon steel plate for mechanical fabrication(S45C),SAE 1345, ect..

Notes on Usage:

- 1.Dry the electrodes at 350-400°C for 60 minutes and keep at 100-150°C before use.
- 2.Preheat the plates at 100-150°C is before welding.
- 3.Keep the arc as short as possible.
- 4.Take the back-step method at the arc starting to prevent blowholes.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Mo	Cr	V
0.065	1.40	0.50	0.02	0.005	1.85	0.30	0.01	0.008

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -50 °c J
668	745	22	60

Welding position:



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

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amps	F	120-150	160-200	180-240
	V&OH	105-125	130-150	-
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20