



AWS	A5.5 E11018-G
EN	EN757 E 69 5 Mn2NiMo B 3 2
JIS	Z3212 D8016

Characteristics:

LKE-11018-G is a low hydrogen electrode for the welding of 760 N/mm² grade high tensile steel. With excellent crack resistance, good mechanical property, bead appearance and lower moisture pick up. It is provided with good arc and easy slag removal.

Applications:

It is suitable for welding of TSTE 620V and TSTE 690V high tensile steel.

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°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
0.07	1.50	0.40	0.02	0.005	2.0	0.35	0.02	0.008

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV J	
			-40°C	-50°C
730	800	22	71	55

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