



LKE-E12018-G

LINKWELD ALLOYS INC.

AWS A5.5 E12018-G
EN EN757 E 79 5 Mn2NiMo B 3 2

Characteristics:

LKE-12018-G is a low hydrogen electrode for the welding of 830 N/mm² grade high tensile steel. With excellent crack resistance, good mechanical property and bead appearance. It is provided with good arc and easy slag removal.

Applications:

It is suitable for welding of heat treatable low alloy steel such as SCM21/4 Cr-Mo steel, SNCM8 Ni-Cr-Mo steel. Proper base metals are also including forging cast iron (ASTM A486 Gr.120/A508 Gr.5a.4a), pressure vessel steel plate (A543 Gr.B3C3), 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 150-200°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
0.06	1.40	0.40	0.025	0.003	2.0	0.4	0.7	0.008

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -50 °C J
840	920	22	50

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