

Classifications

EN 757:1997	: E 62 3 Z B 32 H10	KS D 7006	: E8016
AWS A5.5-06	: E11018-M	JIS Z 3211	: E7618-N4M2

Description

- Covering is low hydrogen, iron powder type for welding of low alloy high strength steels having tensile properties of about 740~790MPa such as HY80, etc.
- Excellent mechanical properties especially in notch toughness.
- Satisfactory bead appearance and slag removal.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.08	0.41	1.49	0.015	0.012	1.86	0.25	0.35	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-50°C	
AWS A5.5	680~760	min. 760	min. 20		≥ 27	
EN 757	min. 620	690~890	min. 18	≥ 47		
Example	730	830	22	80	45	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	50~100 40~90	90~130 80~120	130~180 110~160	180~240 140~200	240~320 -

Approvals

ABS

E11018M-H8

* Others : JIS, CE