

Classifications

EN ISO 2560-A:2006	: E 50 5 Z B 32 H10	KS D 7006	: E5816
AWS A5.5-06	: E9018-M	JIS Z 3211	: E6218-N3M1

Description

- Covering is low hydrogen, iron powder type for welding of 620MPa class high tensile steel in bridge, pressure vessels, penstocks and machinery.
- 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
0.05	0.51	0.88	0.013	0.011	1.58	0.10	0.20	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-40°C	-50°C	
AWS A5.5	540~620	min. 620	min. 24	≥ 27		
EN ISO 2560-A	min. 500	560~720	min. 18	≥ 47		
Example	570	670	30	110	90	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 40~80	90~130 80~115	140~190 110~160	190~240 140~170	250~310 -

Approvals

ABS

E9018M-H8

* Others : JIS, CE