Stick Electrode for Low Temperature Resistant Steel

KN-718G

Type of coating: Iron powder low hydrogen type

Classification

AWS	A 5.5	E7018-G
JIS	Z3211	E4918-G
EN	2560-A	E 42 4 Z B
GB	T 5118	E5018-G

Applications and Features

(1) A low hydrogen coated electrode for 490N/mm^2 grade steel for low temperature resistance.

(2) Weld metal contains 1.5%Ni with good conditions of CVN obtained at -45°C.

(3) It is suitable for Flat and H-Fillet welding.

(4) It is ideal for welding in low temperature resistant steel of LPG storage tanks.(ASTM A537C1, JIS G3126 and SLA325A).

Welding Position

All Positions

Welding Instruction

(1) Clean up the contaminations on the steel. Keep arc as short as possible.

(2) Dry the electrodes 350~400°C in 60 minutes before welding.

(3) Excellent strike and re-strike capabilities with the back step method. (Please refer to Appendix A)

(4) Please note that over welding heat input causes the poor conditions in CVN.

Typical Chemical Composition of Weld Metal (wt %)

C	Si	Mn	P	S	Ni
0.080	0.18	1.14	0.012	0.010	1.60

Typical Mechanical Properties of Weld Metal (PWHT:745°Cx1Hr)

Tensile Strength N/mm^2(kgf/mm^2)	Yield Strength N/mm^2(kgf/mm^2)	Elongation %	Charpy V-Notch °C	Charpy V-Notch J (kgf -m)
550(56.1)	460(46.9)	34	0	—
			-45	98(10.0)

Size and Suggested Operating Range (AC or DC+)

Diameter (mm) x Length(mm)		3.2x350	4.0x400	5.0x400
Amp	F	100~140	140~180	180~230
	V-up/OH	90~130	120~160	—