

Stick Electrode for High Tensile Strength Steel

KL-508

Classification

AWS	A 5.1/A 5.1M	E7018/E4918
JIS	Z3211	E4918
EN	2560-A	E42 3 B 3 2
GB	T5117	E5018

Type of coating: Iron powder low hydrogen type

Applications and Features

- (1) Suitable for welding 490N/mm² grade steel.
- (2) High deposition rate, good mechanical properties of weld metal, good crack resistance and good X-ray soundness.
- (3) Applicable for welding on large steel structures, tanks, pressure vessels. Ideal for that require excellent quality and performance such as pipelines in power plants and petrochemical.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.07	0.30	1.20	0.019	0.006

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
			°C	J
N/mm ²	N/mm ²	%	-29	148
			-40	112

Size and Suggested Operating Range (AC or DC+)

Diameter (mm)	3.2	4.0	5.0	6.0	
Current	F/H-Fillet	90~130	130~180	180~240	230~300
(A)	V-up/OH	80~120	110~160	150~200	-