

Stick Electrode for High Tensile Strength Steel

KL-118

Classification

AWS	A 5.5/A 5.5M	E11018-G/E7618-G
JIS	Z3211	E7618-N4M2
EN	18275-A	E69 2 Z B 3 2
GB	T5117	E8018-G

Type of coating: Iron powder low hydrogen type

Applications and Features

- (1) Suitable for welding 780N/mm² grade steel.
- (2) Good weldability, good mechanical properties and crack resistance.
- (3) Applicable for pressure vessels/pipe, bridges, shipbuilding and offshore structures.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.07	0.23	1.14	0.012	0.008	0.25	2.16	0.43

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
800	690	23	0	145
			-20	105

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	-