

Stick Electrode for High Tensile Strength Steel

KL-108M

Classification

AWS	A 5.5/A 5.5M	E10018-M/E6918-M
JIS	Z3211	E6918-N3M2
EN	18275-A	E62 5 2NiMo B 3 2
GB	T5117	E7018-M

Type of coating: Iron powder low hydrogen type

Applications and Features

- (1) Suitable for welding 690N/mm² grade steel.
- (2) Low diffusible hydrogen content, good crack resistance, good mechanical properties.
- (3) Applicable for Military requirements with HSLA-80.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.47	1.53	0.010	0.006	2.05	0.29	0.06

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
753	689	23	-40	117
			-51	91

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	-