


Classifications:

AWS A5.1 E7018-1
 A5.1M E4918-1
 EN E42 5 B 32 H5
 ISO 2560 B-E4918-1-1A

Characteristics and Applications:

KE7018-1 is an iron powder and low hydrogen type stick electrode designed for all-position welding of 490N/mm² grade high tensile steel. Its welding performance are featured by smooth bead appearance, less spatter, high deposition efficiency, stable arc and easy slag removal. It is suitable for the welding of offshore platform and port machinery..

Welding Position: 

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.150	1.60	0.75	0.20	0.30	0.30	0.035	0.035	0.08
KE7018-1	0.071	1.30	0.45	0.02	0.01	0.15	0.008	0.005	0.002

Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EI(%)	CVN(J/°C)
AWS	400	490	22	27J 45 °C
KE7018-1	470	575	27	100J 45 °C

Notes on Usage:

1. Dry the stick electrodes at 350°C for one hour before welding.
2. Be sure to remove moisture, oil and rust on the base metal.
3. To avoid blowholes when striking the arc, please use backstep method during welding process.
4. Keep short arc length when welding.
5. Current type: DC+ or AC. Using AC is recommended.

Sizes Available and Recommended Parameters:

Diameter (mm)	2.6×350	3.2×350	4.0×400	5.0×400
Current F,H (Amp)	55-85	90-130	130-180	180-240
OH,V	50-80	90-120	130-160	—