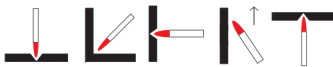


KE11018-M

Characteristics and Applications:

KE11018-M is an iron powder and low hydrogen type stick electrode. The welding features are (1) good for all-position welding (2) the arc is stable (3) good slag detachability (4) less spatter (5) without arc blow deflection situation. It is suitable for the welding of the same strength level low alloy steels.

Welding Position: 

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.10	1.30-1.80	0.60	0.40	1.25-2.50	0.25-0.50	0.03	0.03	0.05
Tested	0.082	1.32	0.52	0.38	1.65	0.38	0.010	0.008	0.01

Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EL%	L.V.(J/°C)
AWS	680-760	760	20	27/-50
Tested	700	820	23	60/-50

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 back step method during welding process.
4. Keep short arc length when welding.
5. Current type : DC or AC.

Sizes Available and Recommended Parameters:

Diameter(mm)	3.2x3.50	4.0x400	5.0x400	6.0x450
Current F.H	90-130	130-180	180-240	240-310
(Amp) OH,V	80-120	110-160	—	—