KE8018-C1

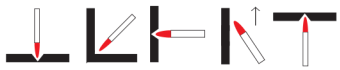
Classifications:

GB/T5118 E5518-C1
AWS A5.5 E8018-C1
A5.5M E5518-C1
EN E 46 6 2N1 B 32
ISO 2560 B-E5518-N5P

Characteristics and Applications:

KE8018-C1 is an iron powder and low hydrogen type stick electrode for all-position welding. In contribution of 2.5%Ni in the weld metal,KE8018-C1 can obtain good notch toughness with impact requirement down to -60^{0}C. It is suitable for the welding of low temperature facilities, such as the steels of 2.5Ni, ASME SA203Gr.A.B.

Welding Position:



Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S
AWS	**0.12**	**1.25**	**0.80**	**--**	**2.00-2.75**	**--**	**0.03**	**0.03**
KE8018-C1	**0.080**	**0.97**	**0.62**	**0.09**	**2.58**	**0.01**	**0.014**	**0.008**

Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EL%	L.V.(J/℃)
AWS	**460**	**550**	**19**	**±**
KE8018-C1	**505**	**592**	**29**	**±**

Notes on Usage :

1.Dry the stick electrodes at 350-400°C for one hour before welding.
2.Be sure to remove moisture, oil and rust on the base metal.
3.Preheat treatment before welding at 90-110°C and try to keep low hydrogen situation during whole welding process.
4.Keep short arc length when welding.
5.To relieve stress, PWHT at 605-635°C.
6.Because of excessive heat input,the impact value tends to be lower.Therefore, choose proper heat input is very important.
7.Current type: DC or AC.

Sizes Available and Recommended Parameters:

Diameter(mm)		2.6x350	3.2x350	4.0x400	5.0x400
Current	F.H	70-100	100-140	140-180	180-230
(Amp)	OH,V	60-90	90-130	120-160	—

CMI
50 Toegye-ro 18-gil, Jung-gu
Seoul, South Korea
www.ecoweldkorea.com