


## Characteristics and Applications:

KE7018 is an iron powder and low hydrogen type stick electrode designed for all-position welding of 490N/mm<sup>2</sup> 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 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
Tested	0.071	1.28	0.40	0.04	0.05	0.15	0.013	0.011	0.01

## Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EL%	L.V.(J/°C)
AWS	400	490	22	27/-45
Tested	490	590	27	128/-46

\*\* NACE MR 0103 & HIC TM-0284 Certification can be made available as per client request\*\*.

## 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. 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	55-85	90-130	130-180	180-240
(Amp) OH,V	50-80	90-120	130-160	—