

Characteristics and Applications:

KE7018-1H4R can be used for welding of high tensile steel, such as bridges, buildings, rolling stock and low temperature used for steel structure.

KE7018-1H4R is an iron powder low hydrogen type electrode. Its coating contains much iron powder, which increasing working efficiency. Its usability is good with direct current applications and very low hydrogen electrode. (HDM<5ml/100g).

Welding Position: 

Typical Chemical Composition of Weld Metal:

C	Si	Mn	P	S
0.06	0.25	1.35	0.014	0.005

Typical Mechanical Properties of Weld Metal:

YS MPa(lbs/in ²)	TS Mpa(lbs/in ²)	EL %	Temp. °C(°F)	CVN-Impact Value J(ft . lbs)
493 (71,500)	566 (82,100)	30.8	-45(-49)	152(112)

Notes Usage:

- 1- Dry the electrodes at 350-400°C (662-752°F) for 60 minutes before use.
- 2- Keep the arc as short as possible, and avoid large width of weaving.
- 3- Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.

Sizes Available and Recommended Parameters:

Diameter(mm)	2.6×350	3.2×350	4.0×400	5.0×400
Current F	0.06 - 90	90 - 140	130 - 190	180 - 240
(Amp) OH,V	50 - 80	80 - 120	120 - 170	150 - 200