

KE11018-G

Classifications:

AWS A5.5 E11018-G


A5.5M E7618-G

EN ISO 18725-A : E69 5 Z B 3 2

EN ISO 18275 B : E7618-N5M4

Characteristics and Applications:

KE11018-G is an iron powder and low hydrogen type stick electrode. It can provide stable arc, easy slag removal, less spatter and radiographic test result. It is suitable for the welding of 750MPa grade high tensile steels.

Welding Position: 

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	--	≥1.00	≥0.80	≥0.30	≥0.50	≥0.20	0.03	0.03	0.10
Tested	0.046	1.30	0.58	0.03	2.58	0.65	0.006	0.005	0.001

Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EL%	L.V.(J/°C)	PWHT°Cxh
AWS	670	760	15	27/-50	620 x 1
Tested	785	840	23	60/-50	620 x 1

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. PWHT & Pass Temperature : 90 - 110°C.
4. PWHT : 620±15°C x 1hr.

Sizes Available and Recommended Parameters:

Diameter(mm)	2.6x3.50	3.2x350	4.0x400	5.0x400
Current F.H	55-85	90-130	130-180	180-240
(Amp) OH,V	50-80	90-120	130-160	—