

Classifications

EN ISO 2560-A:2006	: E 42 3 B 32 H10	KS D 7006	: E5316
EN ISO 2560-B:2006	: E 49 18-G H10	JIS Z 3211	: E5518-G
AWS A5.5-06	: E8018-G		

Description

- Covering is low hydrogen, iron powder type for welding of 560MPa class high tensile steel in ships, bridges, penstocks and rails.
- Excellent mechanical properties and radiographic soundness.
- Satisfactory bead appearance and slag removal.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.56	1.32	0.018	0.011	0.35	0.03	0.25	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.5	min. 460	min. 550	min. 19			
EN ISO 2560-A	min. 460	530~680	min. 20		≥ 47	
Example	490	590	28	95	80	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	60~90 50~80	90~130 80~110	140~190 120~170	180~230 160~200	250~310 -

Approvals

ABS
3Y

* Others : JIS, CE