

Covered Electrodes

AWS E7018

K-7018

AWS E7018-1

K-7018N

Low Hydrogen

AWS E8018-G

K-8018

Typical Applications

Welding of 71 ksi class high tensile strength steels of ships, bridges, storage tanks, building, industrial machinery and mining machinery.

Welding of nuclear reactor vessels, pressure vessels, LPG tankers, LPG storage tanks and similar installations at low temperature.

Welding of 78 ksi class high strength low alloy steel of ships, bridges, storage tanks and buildings.

Characteristics Of Usage

1. Excellent usability with direct current applications.

1. Excellent impact value at -51°F.
2. Excellent mechanical properties.

1. Excellent mechanical properties with good crack resistance of deposited weld metal.

Weld Metal Composition

Carbon	0.07 %
Silicon	0.57 %
Manganese	0.97 %
Phosphorus	0.012 %
Sulphur	0.010 %

Carbon	0.07 %
Silicon	0.58 %
Manganese	1.38 %
Nickel	0.15 %

Carbon	0.06 %
Silicon	0.54 %
Manganese	1.08 %
Nickel	0.31 %
Molybdenum	0.20 %

Mechanical Properties

Y-P (psi)	69,618
T-S (psi)	82,672
EI	30%
V-Notch	66 ft/lb @ -20°F

Y-P (psi)	73,969
T-S (psi)	85,572
EI	32 %
V-Notch	96 ft/lb @ -51°F

Y-P (psi)	71,068
T-S (psi)	85,572
EI	28 %
V-Notch	110 ft/lb @ -20°F

Available Sizes / Rec. Parameters

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	60-100	50-80
1/8 (3.2)	13.8 (350)	90-130	80-120
5/32 (4.0)	15.7 (400)	130-180	110-170
3/16 (5.0)	15.7 (400)	200-250	160-210

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	70-100	60-90
1/8 (3.2)	13.8 (350)	90-130	85-120
5/32 (4.0)	15.7 (400)	150-190	110-160
3/16 (5.0)	15.7 (400)	160-220	130-180
1/4 (6.0)	17.7 (450)	180-230	-

Dia in (mm)	Length in (mm)	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	60-90	50-80
1/8 (3.2)	13.8 (350)	90-130	80-110
5/32 (4.0)	15.7 (400)	140-190	120-170
3/16 (5.0)	15.7 (400)	180-230	160-200
1/4 (6.0)	17.7 (450)	250-300	-

Packaging

10# (5 kg) Carton

10# (5 kg) Carton

10# (5 kg) Carton

[Detailed Packaging Information](#)

[Detailed Packaging Information](#)

[Detailed Packaging Information](#)

Welding Positions

All Welding Positions

All Welding Positions

All Welding Positions

Approved

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS, KS

CWB, DNV, LR

ABS, JIS



KISWEL
WELDING PRODUCTS

Supplier... For The Highest Demands

[SEARCH](#)

[CONTENTS](#)