

## Stick Electrode for High Tensile Strength Steel

# KL-818

### Classification

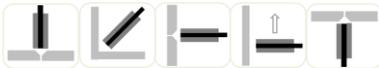
AWS	A 5.5/A 5.5M	E8018-G/E5518-G
JIS	Z3211	E5518-G
EN	2560-A	E50 2 B 3 2
GB	T5117	E5518-G

Type of coating: Iron powder low hydrogen type

### Applications and Features

- (1) Suitable for welding 550N/mm<sup>2</sup> grade steel.
- (2) Good mechanical prosperities, crack resistance and good weldability.
- (3) Applicable for medium/high carbon steel, low manganese alloy steel and high tensile strength steel such as ASTM A516.

### Welding position



### Welding Instruction

Please refer to Appendix A.

### Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.53	1.15	0.012	0.007

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
600	510	32	0	167
			-18	102

### Size and Suggested Operating Range (AC or DC+)

Diameter (mm)		3.2	4.0	5.0	6.0
Current (A)	F/H-Fillet	90~130	130~180	180~240	230~300
	V-up/OH	80~120	110~160	150~200	-