

KL-108

Classification

AWS	A 5.5/A 5.5M	E10018-G/E6918-G
JIS	Z3211	E6918-G
EN	18275-A	E62 2 Z B 3 2
GB	T5117	E7018-G

Type of coating: Iron powder low hydrogen type

Applications and Features

- (1) Suitable for welding 690N/mm² grade steel.
- (2) Low diffusible hydrogen content, which provides good crack resistance and mechanical properties.
- (3) Applicable for the root pass of building hardfacing layers.

Welding position



Welding Instruction

Please refer to Appendix A.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.32	1.00	0.018	0.011	0.32	1.16	0.33

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	℃	J
740	650	23	0	127
			-20	82

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	-