

AK E11018-M

Description: Iron powder low hydrogen potassium type of manual electrode, with high deposition rate, stable arc, beautiful weld bead appearance few spatter, easy slag removal, excellent X-ray results; Stable mechanical properties, excellent low temperature impact toughness.

Application: Suitable for welding of same grade level of low alloy in engineering machinery, such as Q690 and etc..

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Cr	Mo	Ni	V
Requirement	0.10	0.6	1.0-1.8	0.03	0.03	0.4	0.25-0.50	1.25-2.5	0.05
Actual Result	0.067	0.30	1.69	0.005	0.010	0.13	0.38	2.29	0.007

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥760	680-760	≥ 20	≥27J(-50℃)
Actual Result	830	730	24	65

Recommended welding parameters:

Diameter/ mm		2.6	3.2	4.0	5.0
Welding current / A	F/H	80-110	100-130	130-180	180-230
	V/OH	50-80	90-120	120-160	---