



KISWEL

KISWEL – K-8018C3

Classifications:

AWS A5.5: E8018-C3

EN ISO 2560-A: E46 4 1Ni B 3 2 H10

Typical Chemistry Composition of Weld Deposit:

| C | Si | Mn | Cr | Ni | Mo |
|-------|-------|-------------|-------|-------------|-------|
| <0.12 | <0.80 | 0.40 – 1.25 | <0.15 | 0.80 – 1.10 | <0.25 |

Description:

- For welding of high tensile steel used at low temperature and 1%Ni steel.
- It offers excellent mechanical properties, high toughness and crack resistance.

Typical Mechanical Properties:

| Yield Strength (Mpa) | Tensile Strength (Mpa) | Elongation (%) | Impact Value (J) |
|-------------------------|---------------------------|-------------------|---------------------|
| min. 460 | 550 - 740 | min. 20 | 60 (-40°C) |

Packaging:

SMAW Electrode (Ø in mm): 2.60 MM / 3.20 MM / 4.00 MM / 5.00 MM in 20.00 Kg Case

Welding Parameters:

| Wire Diameter | Shielding Gas | Current (A) | |
|---------------|---------------|-------------|------|
| | | Min. | Max. |
| 2.60 mm | | 60 | 100 |
| 3.20 mm | | 80 | 130 |
| 4.00 mm | - | 110 | 180 |
| 5.00 mm | | 150 | 240 |



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