

# LN-218

For welding of aluminum-killed steel for low-temperature

AWS A5.5 E8018-C1

## Applications

Welding of aluminum-killed steel and 2.5%Ni steel used for machinery and equipments for low temperature.

## Characteristics

LN-218 is an low hydrogen, iron powder type electrode for aluminum-killed steel and 2.5%Ni steel used for machinery and equipments for -60°C temperature.

LN-218 also provides good X-ray soundness and good usability.

## Notes on usage

- (1) Pay attention not to exceed heat-input because excessive heat-input causes deterioration of impact values of weld metal.
- (2) Redry the electrodes at 350-400°C for one hour prior to use.
- (3) Adopt back step method or strike the arc on a small steel plate prepared for this particular Purpose to prevent blowholes at the arc starting.
- (4) Keep the arc as short as possible.

## Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Ni
0.04	1.12	0.31	0.009	0.006	2.66

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (kfg/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kfg/mm <sup>2</sup> )	EL %	IV (J)	PWHT
			-60°C	
582	639	28	135	605°C*1hr

## Size & recommended current range (AC or DC+)

Dia. (mm)		2.6	3.2	4.0	5.0	6.0
	L (mm)	350	350	400	400	450
Amp.	F	55-85	90-130	130-180	180-240	250-310
	V & OH	50-80	80-120	110-170	150-200	-

\*Approval : -