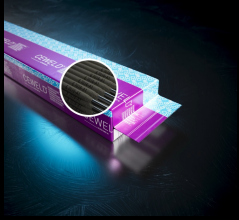


CEWELD E 7018-A1

TYPE	Basic low hydrogen electrode with 0.5% Mo. (Type E Mo, A1)						
APPLICATIONS	CEWELD® E 7018-A1 provides a 0.5%Mo alloyed weld metal. CEWELD® E 7018-A1 can also be used for heat-treated welds. The range of applications extends from joint welding of similar heat-resistant steels and cast steel to joint welding of high-strength structural, fine-grained and pipeline steels with a yield strength of up to 460 MPa.						
PROPERTIES	CEWELD® E 7018-A1 is approved for application temperatures up to 550 °C in the long-term range and shows excellent notched bar impact work at temperatures - 40°C. It is characterized by low moisture absorption and guarantees a low diffusible hydrogen content in the weld metal as well as a yield of 115 %.						
CLASSIFICATION	AWS	A 5.5: E 7018-A1					
	EN ISO	3580-A: E Mo B 42 H5					
	F-nr	4					
	FM	3					
SUITABLE FOR	Typ 0,5Mo ISO 15608: ≤ 460 MPa ; 1.1, 1.2,(~1.3) 1.5415, 1.0481, 1.0482 15 Mo3, 16Mo3 , 20MnMoNi4-5, 15NiCuMoNb5, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE300 ASTM: A 29 Gr. 1013, 1016; A 106 Gr. C; A, B; A 182 Gr. F1; A 234 Gr. WP1; A 283 Gr. B, C, D; A 335 Gr. P1; A 501 Gr. B; A 533 Gr. B, C; A 510 Gr. 1013; A 512 Gr. 1021, 1026; A 513 Gr. 1021, 1026; A 516 Gr. 70; A 633 Gr. C; A 678 Gr. B; A 709 Gr. 36, 50; A 711 Gr. 1013; API 5 L B, X42, X52, X60, X65						
APPROVALS	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Mo	
	0.09	0.5	0.8	0.025	0.02	0.5	
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					-20°C	RT	
	As Welded	570	630	25	50	120	HRc
REDRYING	400°C / 1 hr						
CURRENT TYPE:	AC, DC+						
GAS ACC. EN ISO 14175							



CEWELD E 7018-A1

E 7018-A1 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,4	8720663401182

E 7018-A1 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,4	8720663401205

E 7018-A1 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,2	8720663401229