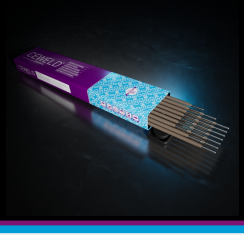


CEWELD E 11018-M

certilas® THE FILLER METAL SPECIALIST

TYPE

High-strength basic coated stick electrode with extremely low H2 content in the weld metal (Type 11018)

APPLICATIONS

CEWELD® E 11018-M is a Mn, Ni, Cr and Mo alloyed highly basic electrode for welding low-alloy steels with a tensile strength ≤ 700 MPa. Used in offshore, crane construction, heavy transport machinery, lifting equipment, etc.

PROPERTIES

CEWELD® E 11018-M is crack resistant and well suited for low temperatures. It shows very good ductility down to -60 °C.
The preheating, interpass temperature and post-weld treatment should be selected as for the base metal.
The hydrogen content is HD < 3 ml/100 g in the weld metal.

CLASSIFICATION

AWS	A 5.5: E 11018-M
EN ISO	18275-A: E 69 5 Mn2NiMo B 42 H5
F-nr	4
FM	2

SUITABLE FOR

1.8914, 1.8927, 1.8931, 1.8928, 1.7147, 1.7149, 1.8734
S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1
L480 - L550, X65, X80, X90, X100, HY 80, HY 100
ASTM A 514 Gr. F, H, Q; A 709 Gr. 100 Type B, E, F, H, Q; A 709 Gr. HPS 100W
Weldox 700, Dillimax 690, Hardox, Naxtra 63, Naxtra 70, Optim 700 mc plus, Weldox 500, Hardox, Domex 460 MC, Domex 500 MC, Domex 550 MC, Domex 600 MC, Domex 650 MC, Domex 700 MC, Hardox 400, XAR 400, Dillidur 400, Oceanfit 100, Oceanfit 690, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni	Mo
0.06	0.3	1.5	2.2	0.4

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -50°C	Hardness
As Welded	705	770	20	65	HRc

REDRYING

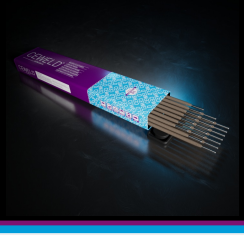
300°C / 2 hr

CURRENT TYPE

DC+

GAS ACC. EN ISO 14175

None



CEWELD E 11018-M

E 11018-M 2,5 X 300MM

Packaging	KG/unit	EanCode
Vacuum	1,8	8720682051368

E 11018-M 3,2 X 350MM

Packaging	KG/unit	EanCode
Vacuum	2,0	8720663424785

E 11018-M 4,0 X 450MM

Packaging	KG/unit	EanCode
Vacuum	2,8	8720682051351