



# CEWELD E 8018-C2

<b>TYPE</b>	Basic Ni alloyed low hydrogen electrode for stick welding	
<b>TOEPASSINGEN</b>	Recommended for fine-grained steels used at low temperature (-60 to -80°C).Cryogenic and petrochemical industries. Stocking and distribution of liquid gas or products volatile.	
<b>EIGENSCHAPPEN</b>	Basic, Nickel alloyed (above 3%) electrode with excellent welding characteristics and easy slag removal. Extreme tough welding deposit with guaranteed excellent mechanical properties at low temperatures.HD < 5 ml/100	
<b>CLASSIFICATIE</b>	AWS	A 5.5: E 8018-C2
	EN ISO	2560-A: E 46 6 3Ni B 42 H5
	F-nr	4
	FM	1
<b>GESCHIKT VOOR</b>	<b>ReH ≤ 460 MPa (67 ksi) ISO 15608: 1.2 (275 &lt; ReH &lt; 360 MPa), 1.3 (ReH &gt; 360 MPa &lt; 460 MPa)</b> 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.1138, 1.5419, 1.8948, 1.8900, 1.8901, 1.8902, 1.8903, 1.8905, 1.8907, 1.8910, 1.8912, 1.8915, 1.8917, 1.8930, 1.8932, 1.8935, 1.8937, 1.8970, 1.8971, 1.8972 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6, S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH- P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2- P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240 AH32, AH36, AH40; DH32, DH36, DH40; EH32, EH36, EH40; FH32. FH36, FH40 ASTM A 203 Gr. D, E; A 350 Gr. LF1, LF2, LF3; A 420 Gr. WPL3, WPL6; A 516 Gr. 60, 65, 70; A 572 Gr. 42, 50, 55, 60, 65; A 633 Gr. A, D, E; A 662 Gr. A, B, C; A 707 Gr. L1, L2, L3; A 738 Gr. A; A 841 A, B, C; API 5 L X52, X60, X65, X52Q, X60Q, X65Q Oceanfit 52, Oceanfit 60, Oceanfit 65, Oceanfit 355, Oceanfit 420, Oceanfit 460, alform plate 460M; durostat 400, 450, durostat B2	

**GOEDKEURINGEN**

**LASPOSITIES**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Ni
0.05	0.3	0.6	0.02	0.02	3.5

**MECHANISCHE WAARDEN**

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-60°C	-76°C	
As Welded	500	620	24	100	75	HRc

**HERDROGEN** 350°C / 2 hr

**GAS ACC. EN ISO 14175**