



CEWELD E 8018-C2

TYPE	Basic Ni alloyed low hydrogen electrode for stick welding		
TOEPASSINGEN	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.		
EIGENSCHAPPEN	Basic, Nickel alloyed (above 3%) electrode with excellent welding characteristics and easy slag removal. Extreme tough welding deposit with guaranteed excelent mechanical properties at low temperatures.HD < 5 ml/100		
CLASSIFICATIE	AWS	A 5.5: E 8018-C2	
	EN ISO	2560-A: E 46 6 3Ni B 42 H5	
	F-nr	4	
	FM	1	
GESCHIKT VOOR	ReH ≤ 460 MPa (67 ksi) ISO 15608: 1.2 (275 < ReH < 360 MPa), 1.3 (ReH > 360 MPa < 460 MPa) 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